

**Garant**
**Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC m6 (mm or inch):  
3**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 123212 3      |
| GTIN         | 4045197570109 |
| Item class   | 11E           |

**Description**
**Version:**

Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry**. High roundness and alignment accuracy of the deep hole, thanks to **4 guide chamfers**. Outstanding chip evacuation due to **4 internal cooling channels** from Ø 3.8 mm. Up to 3.7 mm Ø with 2 internal cooling channels. **Straight major cutting edges** with honed edges and special flute profile for **short chips**, even on long chipping materials.

**Note:**

Flute length  $L_c = L_2 + 1.5 \times D_c$ .

For process reliability when using the 12xD drill, an initial centre drilling with NC spotting drills No. 121068– 121130 is necessary.

Form HB and HE are supplied at the same price as HA.

Order form **HB**: with **No. 123214**.

Order form **HE**: with **No. 123212 + 129100HE**.

Standard: Manufacturer's standard

Tolerance nominal Ø: m6

Number of cutting edges Z: 2

Tolerance nominal Ø: m6

recommended maximum drilling depth  $L_2$ : 49.5 mm

Overall length L: 92 mm

Shank Ø  $D_s$ : 6 mm

Feed f in stainless steel > 900 N/mm<sup>2</sup>: 0.06 mm/rev.

**Technical description**

|                           |       |
|---------------------------|-------|
| Flute length $L_c$        | 54 mm |
| Number of cutting edges Z | 2     |

|                                                   |                         |
|---------------------------------------------------|-------------------------|
| Feed f in stainless steel > 900 N/mm <sup>2</sup> | 0.06 mm/rev.            |
| Nominal Ø D <sub>c</sub>                          | 3 mm                    |
| Shank tolerance                                   | h6                      |
| Tolerance nominal Ø                               | m6                      |
| Shank Ø D <sub>s</sub>                            | 6 mm                    |
| Overall length L                                  | 92 mm                   |
| Standard                                          | Manufacturer's standard |
| recommended maximum drilling depth L <sub>2</sub> | 49.5 mm                 |
| Coating                                           | TiAlN                   |
| Tool material                                     | Solid carbide           |
| Version                                           | 12×D                    |
| Point angle                                       | 135 °                   |
| Shank                                             | DIN 6535 HA to h6       |
| Through-coolant                                   | yes, with 25 bar        |
| Machining strategy                                | HPC                     |
| Semi-Standard                                     | yes                     |
| Colour ring                                       | blue                    |
| Type of product                                   | Jobber drill            |

## User data

|                                | Suitability | V <sub>c</sub> | ISO code |
|--------------------------------|-------------|----------------|----------|
| Steel < 500 N/mm <sup>2</sup>  | suitable    | 90 m/min       | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable    | 75 m/min       | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable    | 70 m/min       | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable    | 55 m/min       | P        |
| Steel < 1400 N/mm <sup>2</sup> | suitable    | 32 m/min       | P        |
| INOX < 900 N/mm <sup>2</sup>   | suitable    | 70 m/min       | M        |
| INOX > 900 N/mm <sup>2</sup>   | suitable    | 60 m/min       | M        |
| wet maximum                    | suitable    |                |          |

|             |          |
|-------------|----------|
| wet minimum | suitable |
|-------------|----------|

**Services**

|                        |           |
|------------------------|-----------|
| Shank grinding Type HE | 129100 HE |
|------------------------|-----------|