Garant

Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, ∅ DC m6 (mm or inch): 9

Order data

Order number	123212 9
GTIN	4045197570345
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 ∅ 3.8 mm. Up to 3.7 mm ∅ 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 12×D 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 ∅: m6
Number of cutting edges Z: 2
Tolerance nominal ∅: m6
recommended maximum drilling depth L_2: 106.5 mm
Overall length L: 162 mm
Shank ∅ D_s: 10 mm
Feed f in stainless steel > 900 N/mm^2: 0.15 mm/rev.

Technical description

Shank tolerance	h6
Nominal ∅ D_C	9 mm

Flute length L_c	120 mm
Feed f in stainless steel > 900 N/mm²	0.15 mm/rev.
Number of cutting edges Z	2
Tolerance nominal ∅	m6
Shank ∅ D_s	10 mm
Overall length L	162 mm
Standard	Manufacturer's standard
recommended maximum drilling depth L_2	106.5 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_c	ISO code
Steel < 500 N/mm²	suitable	90 m/min	P
Steel < 750 N/mm²	suitable	75 m/min	P
Steel < 900 N/mm²	suitable	70 m/min	P
Steel < 1100 N/mm²	suitable	55 m/min	P
Steel < 1400 N/mm²	suitable	32 m/min	P
INOX < 900 N/mm²	suitable	70 m/min	M
INOX > 900 N/mm²	suitable	60 m/min	M
wet maximum	suitable		

wet minimum	suitable

Services

Shank grinding Type HE	129100 HE