

Garant

Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC h7: 1,4mm



Order data

Order number	123110 1,4
GTIN	4045197355768
Item class	11E

Description

Version:

Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry**.

Particularly high alignment accuracy due to **4 guide chamfers** which stabilise the drill even at extreme depths!

Straight major cutting edges with honed edges and special flute profile for **short chips**, even on long chipping materials.

Advantage:

High process reliability and surface quality of the hole.

Note:

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

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

Form **HB**: order with **No. 123115**.

Form **HE**: order with **No. 123110 + 129100 HE**.

Standard: Manufacturer's standard

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

recommended maximum drilling depth L_2 : 12.9 mm

Tolerance nominal Ø: h7

Overall length L: 45 mm

Shank Ø D_s : 4 mm

Feed f in stainless steel < 900 N/mm²: 0.05 mm/rev.

Technical description

Number of cutting edges Z	2
Feed f in stainless steel < 900 N/mm ²	0.05 mm/rev.

Shank tolerance	h6
Nominal $\varnothing D_c$	1.4 mm
Flute length L_c	15 mm
Tolerance nominal \varnothing	h7
Shank $\varnothing D_s$	4 mm
Overall length L	45 mm
Standard	Manufacturer's standard
recommended maximum drilling depth L_2	12.9 mm
Coating	TiAlN
Tool material	Solid carbide
Version	10xD
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
Aluminium (short chipping)	suitable only under restricted conditions	200 m/min	N
Alu > 10% Si	suitable only under restricted conditions	180 m/min	N
Steel < 500 N/mm ²	suitable	110 m/min	P
Steel < 750 N/mm ²	suitable	80 m/min	P
Steel < 900 N/mm ²	suitable	70 m/min	P
INOX < 900 N/mm ²	suitable	65 m/min	M
INOX > 900 N/mm ²	suitable	55 m/min	M

Ti > 850 N/mm ²	suitable	25 m/min	S
wet maximum	suitable		
wet minimum	suitable		