

Garant**Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC h7: 14,5 mm****Order data**

Order number	122690 14,5
GTIN	4062406093037
Item class	11E

Description**Version:****3 guide chamfers** for particularly high accuracy and surface quality at tight hole tolerances.**Asymmetrical tip geometry** for **very high metal removal rates**. New generation of **innovative high-performance drills for cast iron** in the HPC field.**Advantage:**For HPC high performance drilling in castings. **Outstandingly suitable for bainite cast iron (ADI).****Recommendation:****Maximum drilling depth:**

Flute length (see table) less 1.5×nominal Ø.

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. 122690 + 129100HB**.Form **HE**: order with **No. 122690 + 129100HE**.

Standard: DIN 6537

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

Semi-Standard: yes

Tolerance nominal Ø: h7

recommended maximum drilling depth L_2 : 61.3 mm

Overall length L: 133 mm

Shank Ø D_s : 16 mmFeed f in GJS ADI > 800 N/mm²: 0.39 mm/rev.**Technical description**

Standard	DIN 6537
Feed f in GJS ADI > 800 N/mm ²	0.39 mm/rev.
Tolerance nominal Ø	h7
Number of cutting edges Z	2
Flute length L _c	83 mm
Nominal Ø D _c	14.5 mm
Shank Ø D _s	16 mm
Overall length L	133 mm
recommended maximum drilling depth L ₂	61.3 mm
Semi-Standard	yes
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	6×D
Point angle	135 degrees
Shank	DIN 6535 HA to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Colour ring	white
Type of product	Jobber drill

Services

Shank grinding Type HB	129100 HB
Shank grinding Type HE	129100 HE