

**Garant****Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC h7: 14,8 mm****Order data**

|              |               |
|--------------|---------------|
| Order number | 122690 14,8   |
| GTIN         | 4062406093044 |
| 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  $L_2$ : 60.8 mm

Overall length L: 133 mm

Shank Ø  $D_s$ : 16 mmFeed f in GJS ADI > 800 N/mm<sup>2</sup>: 0.39 mm/rev.**Technical description**

|                                                   |                   |
|---------------------------------------------------|-------------------|
| Nominal Ø D <sub>c</sub>                          | 14.8 mm           |
| Flute length L <sub>c</sub>                       | 83 mm             |
| Standard                                          | DIN 6537          |
| Shank Ø D <sub>s</sub>                            | 16 mm             |
| recommended maximum drilling depth L <sub>2</sub> | 60.8 mm           |
| Overall length L                                  | 133 mm            |
| Number of cutting edges Z                         | 2                 |
| Feed f in GJS ADI > 800 N/mm <sup>2</sup>         | 0.39 mm/rev.      |
| Tolerance nominal Ø                               | h7                |
| 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 |