

Garant**Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC h7: 18,5 mm****Order data**

Order number	122690 18,5
GTIN	4062406093143
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 : 73.3 mm

Overall length L: 153 mm

Shank Ø D_s : 20 mmFeed f in GJS ADI > 800 N/mm²: 0.46 mm/rev.**Technical description**

recommended maximum drilling depth L_2	73.3 mm
Tolerance nominal \varnothing	h7
Flute length L_c	101 mm
Feed f in GJS ADI $> 800 \text{ N/mm}^2$	0.46 mm/rev.
Overall length L	153 mm
Number of cutting edges Z	2
Standard	DIN 6537
Nominal $\varnothing D_c$	18.5 mm
Shank $\varnothing D_s$	20 mm
Semi-Standard	yes
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	6xD
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