

**Garant**
**Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC h7: 3,6 mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 122690 3,6    |
| GTIN         | 4062406092436 |
| 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

Tolerance nominal Ø: h7

recommended maximum drilling depth  $L_2$ : 22.6 mm

Overall length L: 66 mm

Shank Ø  $D_s$ : 6 mm

Feed f in GJS ADI > 800 N/mm<sup>2</sup>: 0.16 mm/rev.

**Technical description**

|               |      |
|---------------|------|
| Shank Ø $D_s$ | 6 mm |
|---------------|------|

|                                                   |                   |
|---------------------------------------------------|-------------------|
| Nominal Ø D <sub>c</sub>                          | 3.6 mm            |
| Overall length L                                  | 66 mm             |
| Number of cutting edges Z                         | 2                 |
| Standard                                          | DIN 6537          |
| recommended maximum drilling depth L <sub>2</sub> | 22.6 mm           |
| Tolerance nominal Ø                               | h7                |
| Shank tolerance                                   | h6                |
| Flute length L <sub>c</sub>                       | 28 mm             |
| Feed f in GJS ADI > 800 N/mm <sup>2</sup>         | 0.16 mm/rev.      |
| 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               |
| Semi-Standard                                     | yes               |
| Colour ring                                       | white             |
| Type of product                                   | Jobber drill      |

## Services

|                        |           |
|------------------------|-----------|
| Shank grinding Type HB | 129100 HB |
| Shank grinding Type HE | 129100 HE |