

Garant
Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC h7: 4,9 mm

Order data

| | |
|--------------|---------------|
| Order number | 122690 4,9 |
| GTIN | 4062406092528 |
| 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 : 36.7 mm

Overall length L: 82 mm

Shank Ø D_s : 6 mm

Feed f in GJS ADI > 800 N/mm²: 0.16 mm/rev.

Technical description

| | |
|---------------------------|---|
| Number of cutting edges Z | 2 |
|---------------------------|---|

| | |
|---|-------------------|
| Shank $\varnothing D_s$ | 6 mm |
| Overall length L | 82 mm |
| recommended maximum drilling depth L_2 | 36.7 mm |
| Shank tolerance | h6 |
| Standard | DIN 6537 |
| Flute length L_c | 44 mm |
| Nominal $\varnothing D_c$ | 4.9 mm |
| Tolerance nominal \varnothing | h7 |
| Feed f in GJS ADI > 800 N/mm ² | 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 HE | 129100 HE |
| Shank grinding Type HB | 129100 HB |