Garant

Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, ⌀ DC h7: 8,7 mm

Order data

Order number	122690 8,7
GTIN	4062406092788
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 ⌀.
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 ⌀: h7
Number of cutting edges Z: 2
Tolerance nominal ⌀: h7
recommended maximum drilling depth L_2: 48 mm
Overall length L: 103 mm
Shank ⌀ D_s: 10 mm
Feed f in GJS ADI > 800 N/mm ^{2}: 0.29 mm/rev.

Technical description

Overall length L	103 mm

Tolerance nominal Ø	h7
Nominal Ø D_C	8.7 mm
Flute length L_c	61 mm
Feed f in GJS ADI > 800 N/mm ^{2}	0.29 mm/rev.
Standard	DIN 6537
recommended maximum drilling depth L_2	48 mm
Number of cutting edges Z	2
Shank Ø D_s	10 mm
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
Semi-Standard	yes
Colour ring	white
Type of product	Jobber drill

Services

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