

Garant
Solid carbide HPC drill, plain shank DIN 6535 HA, DLC, Ø DC h7: 19,5 mm

Order data

| | |
|--------------|---------------|
| Order number | 122808 19,5 |
| GTIN | 4045197754639 |
| Item class | 11E |

Description
Version:

DLC coating sp^2 of the latest generation with **low coefficient of friction** results in **outstanding chip clearance**. For **high-performance milling** of **aluminium materials**. **High roundness** and **alignment accuracy of the deep hole**, thanks to **6 guide chamfers**.

Recommendation:
Maximum drilling depth:

flute length (see table) less $1.5 \times \text{nominal } \varnothing$.

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. 122809**.

Form **HE**: order with **No. 122808 + 129100HE**.

Standard: Manufacturer's standard

Tolerance nominal \varnothing : h7

Number of cutting edges Z: 2

Tolerance nominal \varnothing : h7

recommended maximum drilling depth L_2 : 160.8 mm

Overall length L: 243 mm

Shank $\varnothing D_s$: 20 mm

Feed f in aluminium short-chipping: 0.7 mm/rev.

Technical description

| | |
|---------------------------|--------|
| Flute length L_c | 190 mm |
| Number of cutting edges Z | 2 |
| Overall length L | 243 mm |

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|--|-------------------------|
| Nominal $\varnothing D_c$ | 19.5 mm |
| Shank tolerance | h6 |
| Tolerance nominal \varnothing | h7 |
| Shank $\varnothing D_s$ | 20 mm |
| Standard | Manufacturer's standard |
| Feed f in aluminium short-chipping | 0.7 mm/rev. |
| recommended maximum drilling depth L_2 | 160.8 mm |
| Coating | DLC |
| Tool material | solid carbide |
| Drill depth up to | 8×D |
| Type | W |
| Point angle | 135 degrees |
| Shank | DIN 6535 HA to h6 |
| Through-coolant | yes, with 25 bar |
| Machining strategy | HPC |
| Semi-Standard | yes |
| Colour ring | yellow |
| Type of product | Jobber drill |

Services

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