

## Garant

### Solid carbide HPC drill, plain shank DIN 6535 HA, DLC, Ø DC h7: 3,8 mm



#### Order data

Order number	122808 3,8
GTIN	4045197753724
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  $L_2$ : 37.3 mm

Overall length L: 81 mm

Shank  $\varnothing D_s$ : 6 mm

Feed f in aluminium short-chipping: 0.35 mm/rev.

#### Technical description

Standard	Manufacturer's standard
Feed f in aluminium short-chipping	0.35 mm/rev.
Flute length $L_c$	43 mm

Number of cutting edges Z	2
Shank tolerance	h6
Overall length L	81 mm
Shank $\varnothing D_s$	6 mm
Nominal $\varnothing D_c$	3.8 mm
Tolerance nominal $\varnothing$	h7
recommended maximum drilling depth $L_2$	37.3 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

Shank grinding Type HE	129100 HE
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