

## Garant

### Solid carbide HPC drill, plain shank DIN 6535 HA, DLC, Ø DC h7: 5,3 mm



#### Order data

|              |               |
|--------------|---------------|
| Order number | 122808 5,3    |
| GTIN         | 4045197753878 |
| 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  $L_2$ : 49.1 mm

Overall length L: 95 mm

Shank  $\varnothing D_s$ : 6 mm

Feed f in aluminium short-chipping: 0.45 mm/rev.

#### Technical description

|                                 |      |
|---------------------------------|------|
| Tolerance nominal $\varnothing$ | h7   |
| Shank $\varnothing D_s$         | 6 mm |
| Shank tolerance                 | h6   |

|  |                         |
|--|-------------------------|
| Flute length $L_c$                       | 57 mm                   |
| Standard                                 | Manufacturer's standard |
| Feed $f$ in aluminium short-chipping     | 0.45 mm/rev.            |
| Overall length $L$                       | 95 mm                   |
| Nominal $\varnothing D_c$                | 5.3 mm                  |
| Number of cutting edges $Z$              | 2                       |
| recommended maximum drilling depth $L_2$ | 49.1 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 |
|------------------------|-----------|