

**Garant**
**Solid carbide HPC drill, plain shank DIN 6535 HA, DLC, Ø DC h7: 7 mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 122808 7      |
| GTIN         | 4045197754042 |
| 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  $L_2$ : 65.5 mm

Overall length L: 114 mm

Shank  $\varnothing D_s$ : 8 mm

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

**Technical description**

|                                    |              |
|------------------------------------|--------------|
| Feed f in aluminium short-chipping | 0.45 mm/rev. |
| Number of cutting edges Z          | 2            |
| Tolerance nominal $\varnothing$    | h7           |

|                                                   |                         |
|---------------------------------------------------|-------------------------|
| Nominal Ø D <sub>c</sub>                          | 7 mm                    |
| Standard                                          | Manufacturer's standard |
| Shank Ø D <sub>s</sub>                            | 8 mm                    |
| Overall length L                                  | 114 mm                  |
| Shank tolerance                                   | h6                      |
| Flute length L <sub>c</sub>                       | 76 mm                   |
| recommended maximum drilling depth L <sub>2</sub> | 65.5 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 |
|------------------------|-----------|