

**Garant**
**Solid carbide HPC drill, plain shank DIN 6535 HA, DLC, Ø DC h7: 8,4 mm**

**Order data**

Order number	122306 8,4
GTIN	4045197751621
Item class	11E

**Description**
**Version:**

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

Size 1 - 1.5 with 4 guide chamfers.

**Recommendation:**
**Maximum drilling depth:**

flute length (see table) less 1.5×nominal Ø.

**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. 122307**.

Form **HE**: order with **No. 122306 + 129100HE**.

Standard: DIN 6537 K

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

Tolerance nominal Ø: h7

recommended maximum drilling depth  $L_2$ : 34.4 mm

Overall length L: 89 mm

Shank Ø  $D_s$ : 10 mm

Feed f in aluminium short-chipping: 0.55 mm/rev.

**Technical description**

Tolerance nominal Ø	h7
Overall length L	89 mm

Shank $\varnothing D_s$	10 mm
Feed f in aluminium short-chipping	0.55 mm/rev.
Nominal $\varnothing D_c$	8.4 mm
Flute length $L_c$	47 mm
Shank tolerance	h6
Number of cutting edges Z	2
Standard	DIN 6537 K
recommended maximum drilling depth $L_2$	34.4 mm
Coating	DLC
Tool material	solid carbide
Drill depth up to	4xD
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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