

**Garant**
**Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC h7: 6,8 mm**


## Order data

Order number	122500 6,8
GTIN	4045197050304
Item class	11E

## Description

### Version:

Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry**. **Convex cutting edges** with honed edges and special flute profile for **short chips**, even on long chipping materials.

### Recommendation:

#### Maximum drilling depth:

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

### Note:

Form HB and HE supplied at the same price as HA.

Form **HB**: order with **No. 122445/122505**.

Form **HE**: order with **No. 122440/122500** and **129100HE**.

Flute length  $L_c = L_2 + 1.5 \times D_c$ .

### NEW GENERATION AVAILABLE!

**Recommended successor products are No. 122415; 122425; 122435 and 122361, as well as 122371.**

Standard: DIN 6537 K

Tolerance nominal  $\varnothing$ : h7

Number of cutting edges Z: 2

Tolerance nominal  $\varnothing$ : h7

recommended maximum drilling depth  $L_2$ : 23.8 mm

Overall length L: 79 mm

Shank  $\varnothing D_s$ : 8 mm

Feed f in steel  $< 1100 \text{ N/mm}^2$ : 0.2 mm/rev.

## Technical description

Number of cutting edges Z	2
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Flute length $L_c$	34 mm
Nominal $\varnothing D_c$	6.8 mm
Feed $f$ in steel $< 1100 \text{ N/mm}^2$	0.2 mm/rev.
Shank tolerance	h6
Tolerance nominal $\varnothing$	h7
Shank $\varnothing D_s$	8 mm
Overall length $L$	79 mm
Standard	DIN 6537 K
recommended maximum drilling depth $L_2$	23.8 mm
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	4xD
Point angle	140 degrees
Shank	DIN 6535 HA to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Semi-Standard	yes
Colour ring	green
Type of product	Jobber drill

## Services

Shank grinding Type HE	129100 HE
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