

**Garant**
**Solid carbide HPC drill plain shank DIN 6535 HA, DLC, Ø DC p6: 2,4 mm**

**Order data**

Order number	122606 2,4
GTIN	4045197567956
Item class	11E

**Description**
**Version:**

Spiral fluted, with **6 guide chamfers** and internal cooling channels.

New generation of high performance pilot drills in the HPC range.

With **140° point angle** and special **p6 cutting edge tolerance** for optimum generation of a pilot hole. High alignment accuracy and **roundness of the pilot hole**.

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

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

**Note:**

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

For deep-hole drilling deeper than 16×D a pilot hole is recommended, and for deep-hole drilling from 20×D to 30×D it is essential. **The generation of a pilot hole improves process reliability.**

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

Form **HB**: order with **No. 122608**.

Form **HE**: order with **No. 122606 + 129100HE**.

Standard: DIN 6537

Tolerance nominal Ø: p6

Number of cutting edges Z: 2

Tolerance nominal Ø: p6

recommended maximum drilling depth  $L_2$ : 17.4 mm

Overall length L: 57 mm

Shank Ø  $D_s$ : 4 mm

Feed f in aluminium short-chipping: 0.18 mm/rev.

**Technical description**

Number of cutting edges Z	2
---------------------------	---

Shank tolerance	h6
Nominal $\varnothing D_c$	2.4 mm
Feed f in aluminium short-chipping	0.18 mm/rev.
Flute length $L_c$	21 mm
Tolerance nominal $\varnothing$	p6
Shank $\varnothing D_s$	4 mm
Overall length L	57 mm
Standard	DIN 6537
recommended maximum drilling depth $L_2$	17.4 mm
Coating	DLC
Tool material	Solid carbide
Drill depth up to	6×D
Type	W
Point angle	140 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