

**Garant**
**Solid carbide HPC drill plain shank DIN 6535 HA, DLC, Ø DC p6: 7,8 mm**

**Order data**

Order number	122606 7,8
GTIN	4045197568205
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  $L_2$ : 41.3 mm

Overall length L: 91 mm

Shank Ø  $D_s$ : 8 mm

Feed f in aluminium short-chipping: 0.36 mm/rev.

**Technical description**

Number of cutting edges Z	2
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Flute length $L_c$	53 mm
Feed $f$ in aluminium short-chipping	0.36 mm/rev.
Nominal $\varnothing D_c$	7.8 mm
Shank tolerance	h6
Tolerance nominal $\varnothing$	p6
Shank $\varnothing D_s$	8 mm
Overall length $L$	91 mm
Standard	DIN 6537
recommended maximum drilling depth $L_2$	41.3 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

## Services

Shank grinding Type HE	129100 HE
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