

Garant
Solid carbide HPC drill plain shank DIN 6535 HA, DLC, Ø DC p6: 8,5 mm

Order data

Order number	122606 8,5
GTIN	4045197568236
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 : 48.3 mm

Overall length L: 103 mm

Shank Ø D_s : 10 mm

Feed f in aluminium short-chipping: 0.44 mm/rev.

Technical description

Nominal Ø D_c	8.5 mm
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Flute length L_c	61 mm
Number of cutting edges Z	2
Shank tolerance	h6
Feed f in aluminium short-chipping	0.44 mm/rev.
Tolerance nominal \varnothing	p6
Shank $\varnothing D_s$	10 mm
Overall length L	103 mm
Standard	DIN 6537
recommended maximum drilling depth L_2	48.3 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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