Garant

Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, ∅ DC m6 (∅ DC X = h7): 0,9 mm or inch

Order data

Order number	122659 0,9
GTIN	4045197582201
Item class	11E

Description

Version:
Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry.** High roundness and alignment accuracy of the deep hole, thanks to **4 guide chamfers.** Outstanding chip evacuation due to **4 internal cooling channels** from ∅ 3.8 mm. Up to 3.7 mm ∅ with 2 internal cooling channels. **Straight major cutting edges** with honed edges and special flute profile for **short chips**, even on long chipping materials.
Recommendation:
Maximum drilling depth:
Flute length (see table) less 1.5×nominal ∅.
Attention:
Sizes **ending with X** = cutter ∅ tolerance **h7.**
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. 122661**.
Form **HE:** order with **No. 122659 + 129100HE**.
Machining strategy: HPC
Standard: DIN 6537
Tolerance nominal ∅: m6
Number of cutting edges Z: 2
Semi-Standard: yes
Tolerance nominal ∅: m6
recommended maximum drilling depth L_2: 6.7 mm
Overall length L: 55 mm
Shank ∅ D_s: 4 mm
Feed f in stainless steel > 900 N/mm^2: 0.017 mm/rev.

Technical description

Shank tolerance	h6
Nominal ⌀ D_C	0.9 mm
Flute length L_c	8 mm
Feed f in stainless steel > 900 N/mm^2	0.017 mm/rev.
Number of cutting edges Z	2
Tolerance nominal ⌀	m6
Shank ⌀ D_s	4 mm
Overall length L	55 mm
Standard	DIN 6537
recommended maximum drilling depth L_2	6.7 mm
Semi-Standard	yes
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	6×D
Point angle	140 degrees
Shank	DIN 6535 HA to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Colour ring	blue
Type of product	Jobber drill