

## Garant

**Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC m6 (Ø DC X = h7)  
(mm or inch): 17,85 mm or inch**



### Order data

Order number	122659 17,85
GTIN	4045197583079
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 Ø 3.8 mm. Up to 3.7 mm Ø 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 Ø.

##### Attention:

Sizes **ending with X** = cutter Ø 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**.

Standard: DIN 6537

Tolerance nominal Ø: m6

Number of cutting edges Z: 2

Tolerance nominal Ø: m6

recommended maximum drilling depth  $L_2$ : 66.3 mm

Overall length L: 143 mm

Shank Ø  $D_s$ : 18 mm

Feed f in stainless steel > 900 N/mm<sup>2</sup>: 0.25 mm/rev.

### Technical description

Flute length $L_c$	93 mm
Shank tolerance	h6
Nominal $\varnothing D_c$	17.85 mm
Number of cutting edges Z	2
Feed f in stainless steel > 900 N/mm <sup>2</sup>	0.25 mm/rev.
Tolerance nominal $\varnothing$	m6
Shank $\varnothing D_s$	18 mm
Overall length L	143 mm
Standard	DIN 6537
recommended maximum drilling depth $L_2$	66.3 mm
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	6×D
Point angle	140 degrees
Cutting direction	right-hand
Shank	DIN 6535 HA to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Semi-Standard	yes
Colour ring	blue
Type of product	Jobber drill

## Services

Shank grinding Type HE	129100 HE
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