

## Garant

**Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC m6 (Ø DC X = h7)  
(mm or inch): 4,1 mm or inch**



### Order data

|              |               |
|--------------|---------------|
| Order number | 122659 4,1    |
| GTIN         | 4045197454843 |
| 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  $L_2$ : 29.9 mm

Overall length L: 74 mm

Shank Ø  $D_s$ : 6 mm

Feed f in stainless steel > 900 N/mm<sup>2</sup>: 0.08 mm/rev.

### Technical description

|   |                   |
|---|-------------------|
| Flute length $L_c$                                | 36 mm             |
| Shank tolerance                                   | h6                |
| Number of cutting edges Z                         | 2                 |
| Nominal $\varnothing D_c$                         | 4.1 mm            |
| Feed f in stainless steel > 900 N/mm <sup>2</sup> | 0.08 mm/rev.      |
| Tolerance nominal $\varnothing$                   | m6                |
| Shank $\varnothing D_s$                           | 6 mm              |
| Overall length L                                  | 74 mm             |
| Standard  | DIN 6537          |
| recommended maximum drilling depth $L_2$          | 29.9 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 |
|------------------------|-----------|