

Garant

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



Order data

| | |
|--------------|---------------|
| Order number | 122659 4,4 |
| GTIN | 4045197454874 |
| 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 : 29.4 mm

Overall length L: 74 mm

Shank Ø D_s : 6 mm

Feed f in stainless steel > 900 N/mm²: 0.08 mm/rev.

Technical description

| | |
|---------------------------------------------------|-------------------|
| Shank tolerance | h6 |
| Feed f in stainless steel > 900 N/mm ² | 0.08 mm/rev. |
| Nominal Ø D _c | 4.4 mm |
| Flute length L _c | 36 mm |
| Number of cutting edges Z | 2 |
| Tolerance nominal Ø | m6 |
| Shank Ø D _s | 6 mm |
| Overall length L | 74 mm |
| Standard | DIN 6537 |
| recommended maximum drilling depth L ₂ | 29.4 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

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|------------------------|-----------|
| Shank grinding Type HE | 129100 HE |
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