Garant

Solid carbide HPC drill plain shank DIN 6535 HA, TiAIN, Ø DC m6 (Ø DC X = h7) (mm or inch): 5,7 mm or inch

Arman

Order data

Order number	122659 5,7
GTIN	4045197456007
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 $1.5 \times nominal \emptyset$.

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 : 35.5 mm Overall length L: 82 mm Shank Ø D_s: 6 mm Feed f in stainless steel > 900 N/mm²: 0.12 mm/rev.

Technical description

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Data sheet

Nominal Ø Dc5.7 mmNumber of cutting edges Z2Shank toleranceh6Feed f in stainless steel > 900 N/mm²0.12 mm/rev.Tolerance nominal Øm6Shank Ø D,6 mmOverall length L82 mmStandardDIN 6537recommended maximum drilling depth L235.5 mmCoatingTiAINTool materialSolid carbideDrill depth up to6 xDPoint angle140 degreesCutting directionright-handShankDIN 6535 HA to h6Through-coolantyes, with 25 barMachining strategyHPCSemi-StandardyesColour ringblue	Flute length L _c	44 mm
Shank toleranceh6Feed f in stainless steel > 900 N/mm²0.12 mm/rev.Tolerance nominal Øm6Shank Ø D,6 mmOverall length L82 mmStandardDIN 6537recommended maximum drilling depth L₂35.5 mmCoatingTiAlNTool materialSolid carbideDrill depth up to6×DPoint angle140 degreesCutting directionright-handShankDIN 6535 HA to h6Through-coolantyes, with 25 barMachining strategyHPCSemi-Standardyes	Nominal Ø D _c	5.7 mm
Feed f in stainless steel > 900 N/mm²0.12 mm/rev.Tolerance nominal Øm6Shank Ø D,6 mmOverall length L82 mmStandardDIN 6537recommended maximum drilling depth L235.5 mmCoatingTiAlNTool materialSolid carbideDrill depth up to6 xDPoint angle140 degreesCutting directionright-handShankDIN 6535 HA to h6Through-coolantyes, with 25 barMachining strategyHPCSemi-Standardyes	Number of cutting edges Z	2
Tolerance nominal Øm6Shank Ø D_s6 mmOverall length L82 mmStandardDIN 6537recommended maximum drilling depth L235.5 mmCoatingTiAINTool materialSolid carbideDrill depth up to6×DPoint angle140 degreesCutting directionright-handShankDIN 6535 HA to h6Through-coolantyes, with 25 barMachining strategyHPCSemi-Standardyes	Shank tolerance	h6
Shank Ø D,6 mmOverall length L82 mmStandardDIN 6537recommended maximum drilling depth L235.5 mmCoatingTiAINTool materialSolid carbideDrill depth up to6×DPoint angle140 degreesCutting directionright-handShankDIN 6535 HA to h6Through-coolantyes, with 25 barMachining strategyHPCSemi-Standardyes	Feed f in stainless steel > 900 N/mm ²	0.12 mm/rev.
Overall length L82 mmStandardDIN 6537recommended maximum drilling depth L235.5 mmCoatingTiAINCoatingSolid carbideTool materialSolid carbideDrill depth up to6×DPoint angle140 degreesCutting directionright-handShankDIN 6535 HA to h6Through-coolantyes, with 25 barMachining strategyHPCSemi-Standardyes	Tolerance nominal Ø	тб
StandardDIN 6537recommended maximum drilling depth L235.5 mmCoatingTiAINTool materialSolid carbideDrill depth up to6×DPoint angle140 degreesCutting directionright-handShankDIN 6535 HA to h6Through-coolantyes, with 25 barMachining strategyHPCSemi-Standardyes	Shank Ø D _s	6 mm
recommended maximum drilling depth L235.5 mmCoatingTiAINTool materialSolid carbideDrill depth up to6×DPoint angle140 degreesCutting directionright-handShankDIN 6535 HA to h6Through-coolantyes, with 25 barMachining strategyHPCSemi-Standardyes	Overall length L	82 mm
CoatingTiAINTool materialSolid carbideDrill depth up to6×DPoint angle140 degreesCutting directionright-handShankDIN 6535 HA to h6Through-coolantyes, with 25 barMachining strategyHPCSemi-Standardyes	Standard	DIN 6537
Tool materialSolid carbideDrill depth up to6×DPoint angle140 degreesCutting directionright-handShankDIN 6535 HA to h6Through-coolantyes, with 25 barMachining strategyHPCSemi-Standardyes	recommended maximum drilling depth L_2	35.5 mm
Drill depth up to6×DPoint angle140 degreesCutting directionright-handShankDIN 6535 HA to h6Through-coolantyes, with 25 barMachining strategyHPCSemi-Standardyes	Coating	TiAIN
Point angle140 degreesCutting directionright-handShankDIN 6535 HA to h6Through-coolantyes, with 25 barMachining strategyHPCSemi-Standardyes	Tool material	Solid carbide
Cutting directionright-handShankDIN 6535 HA to h6Through-coolantyes, with 25 barMachining strategyHPCSemi-Standardyes	Drill depth up to	6×D
ShankDIN 6535 HA to h6Through-coolantyes, with 25 barMachining strategyHPCSemi-Standardyes	Point angle	140 degrees
Through-coolantyes, with 25 barMachining strategyHPCSemi-Standardyes	Cutting direction	right-hand
Machining strategyHPCSemi-Standardyes	Shank	DIN 6535 HA to h6
Semi-Standard yes	Through-coolant	yes, with 25 bar
	Machining strategy	HPC
Colour ring blue	Semi-Standard	yes
	Colour ring	blue
Type of product Jobber drill	Type of product	Jobber drill

Services

Shank grinding Type HE	129100 HE