

## Garant

### Solid carbide HPC drill type FS plain shank DIN 6535 HA, TiAlN, Ø DC h7: 14 mm



#### Order data

|              |               |
|--------------|---------------|
| Order number | 122670 14     |
| GTIN         | 4045197057068 |
| Item class   | 11E           |

#### Description

##### Version:

**Particularly strong** due to strengthened core and **special profile**. Special point geometry.

**High concentricity** and **long tool life**.

**High bore quality**.

##### Recommendation:

##### Maximum drilling depth:

flute length (see table) less  $1.5 \times \text{nominal } \varnothing$ .

##### 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. 122675**.

Form **HE**: order with **No. 122670 + 129100HE**.

Standard: DIN 6537

Tolerance nominal  $\varnothing$ : h7

Number of cutting edges Z: 2

Tolerance nominal  $\varnothing$ : h7

recommended maximum drilling depth  $L_2$ : 56 mm

Overall length L: 124 mm

Shank  $\varnothing D_s$ : 14 mm

Feed f in titanium  $> 850 \text{ N/mm}^2$ : 0.16 mm/rev.

#### Technical description

|                           |       |
|---------------------------|-------|
| Nominal $\varnothing D_c$ | 14 mm |
| Number of cutting edges Z | 2     |

|   |                   |
|---|-------------------|
| Shank tolerance                                   | h6                |
| Feed f in titanium > 850 N/mm <sup>2</sup>        | 0.16 mm/rev.      |
| Flute length L <sub>c</sub>                       | 77 mm             |
| Tolerance nominal Ø                               | h7                |
| Shank Ø D <sub>s</sub>                            | 14 mm             |
| Overall length L                                  | 124 mm            |
| Standard  | DIN 6537          |
| recommended maximum drilling depth L <sub>2</sub> | 56 mm             |
| Coating   | TiAlN             |
| Tool material                                     | Solid carbide     |
| Drill depth up to                                 | 6×D               |
| Type  | FS                |
| Point angle                                       | 140 degrees       |
| Shank   | DIN 6535 HA to h6 |
| Through-coolant                                   | yes, with 25 bar  |
| Machining strategy                                | HPC               |
| Semi-Standard                                     | yes               |
| Colour ring                                       | pink              |
| Type of product                                   | Jobber drill      |

## Services

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