

Garant

Solid carbide HPC drill type FS plain shank DIN 6535 HA, TiAlN, Ø DC h7: 18,5 mm



Order data

Order number	122670 18,5
GTIN	4045197057198
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

Semi-Standard: yes

Tolerance nominal \varnothing : h7

recommended maximum drilling depth L_2 : 73.3 mm

Overall length L: 153 mm

Shank $\varnothing D_s$: 20 mm

Feed f in titanium $> 850 \text{ N/mm}^2$: 0.2 mm/rev.

Technical description

Nominal $\varnothing D_c$	18.5 mm
Number of cutting edges Z	2

Shank tolerance	h6
Feed f in titanium > 850 N/mm ²	0.2 mm/rev.
Flute length L _c	101 mm
Tolerance nominal Ø	h7
Shank Ø D _s	20 mm
Overall length L	153 mm
Standard	DIN 6537
recommended maximum drilling depth L ₂	73.3 mm
Semi-Standard	yes
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
Colour ring	pink
Type of product	Jobber drill

Services

Shank grinding Type HE	129100 HE
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