

## Garant

### Solid carbide HPC drill type FS plain shank DIN 6535 HA, TiAlN, Ø DC h7: 19 mm



#### Order data

Order number	122670 19
GTIN	4045197057204
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  $L_2$ : 72.5 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

Shank tolerance	h6
Nominal $\varnothing D_c$	19 mm

Number of cutting edges Z	2
Flute length L <sub>c</sub>	101 mm
Feed f in titanium > 850 N/mm <sup>2</sup>	0.2 mm/rev.
Tolerance nominal Ø	h7
Shank Ø D <sub>s</sub>	20 mm
Overall length L	153 mm
Standard	DIN 6537
recommended maximum drilling depth L <sub>2</sub>	72.5 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
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