

Garant

Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC h7: 4 mm



Order data

Order number	122690 4
GTIN	4045197597014
Item class	11E

Description

Version:

3 guide chamfers for particularly high accuracy and surface quality at tight hole tolerances.
Asymmetrical tip geometry for **very high metal removal rates**. New generation of **innovative high-performance drills for cast iron** in the HPC field.

Advantage:

For HPC high performance drilling in castings. **Outstandingly suitable for bainite cast iron (ADI)**.

Recommendation:

Maximum drilling depth:

Flute length (see table) less 1.5×nominal Ø.

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. 122690 + 129100HB** .

Form **HE**: order with **No. 122690 + 129100HE**.

Standard: DIN 6537

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

Tolerance nominal Ø: h7

recommended maximum drilling depth L_2 : 30 mm

Overall length L: 74 mm

Shank Ø D_s : 6 mm

Feed f in GJS ADI > 800 N/mm²: 0.16 mm/rev.

Technical description

Nominal Ø D_c	4 mm
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Shank tolerance	h6
Number of cutting edges Z	2
Flute length L _c	36 mm
Feed f in GJS ADI > 800 N/mm ²	0.16 mm/rev.
Tolerance nominal Ø	h7
Shank Ø D _s	6 mm
Overall length L	74 mm
Standard	DIN 6537
recommended maximum drilling depth L ₂	30 mm
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	6×D
Point angle	135 degrees
Shank	DIN 6535 HA to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Semi-Standard	yes
Colour ring	white
Type of product	Jobber drill

Services

Shank grinding Type HE	129100 HE
Shank grinding Type HB	129100 HB