

## Garant

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



#### Order data

Order number	122690 5
GTIN	4045197597045
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  $L_2$ : 36.5 mm

Overall length L: 82 mm

Shank Ø  $D_s$ : 6 mm

Feed f in GJS ADI > 800 N/mm<sup>2</sup>: 0.22 mm/rev.

#### Technical description

Flute length $L_c$	44 mm
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Feed f in GJS ADI > 800 N/mm <sup>2</sup>	0.22 mm/rev.
Shank tolerance	h6
Nominal Ø D <sub>c</sub>	5 mm
Number of cutting edges Z	2
Tolerance nominal Ø	h7
Shank Ø D <sub>s</sub>	6 mm
Overall length L	82 mm
Standard	DIN 6537
recommended maximum drilling depth L <sub>2</sub>	36.5 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