

## Garant

### Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC p6: 6,8 mm



## Order data

Order number	122736 6,8
GTIN	4045197567154
Item class	11E

## Description

### Version:

Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry**. High roundness and alignment accuracy of the deep hole, thanks to **4 guide chamfers**. Outstanding chip evacuation due to **4 internal cooling channels** from Ø 3.8 mm. Up to 3.7 mm Ø with 2 internal cooling channels. With **140° point angle** and special **j6 cutting edge tolerance** for optimum generation of a pilot hole.

### Recommendation:

#### Maximum drilling depth:

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

#### Note:

Flute length  $L_c = L_2 + 1.5 \times D_c$ .

For deep-hole drilling deeper than 12×D a pilot hole is recommended, and for deep-hole drilling from 20×D to 30×D it is essential.

#### The generation of a pilot hole improves process reliability.

Form HB and HE supplied at the same price as HA.

Form **HB**: order with **No. 122738**.

Form **HE**: order with **No. 122736 + 129100HE**.

Standard: DIN 6537

Tolerance nominal Ø: p6

Number of cutting edges Z: 2

Tolerance nominal Ø: p6

recommended maximum drilling depth  $L_2$ : 42.8 mm

Overall length L: 91 mm

Shank Ø  $D_s$ : 8 mm

Feed  $f$  in steel < 1100 N/mm<sup>2</sup>: 0.21 mm/rev.

## Technical description

Feed f in steel < 1100 N/mm <sup>2</sup>	0.21 mm/rev.
Nominal Ø D <sub>c</sub>	6.8 mm
Shank tolerance	h6
Number of cutting edges Z	2
Flute length L <sub>c</sub>	53 mm
Tolerance nominal Ø	p6
Shank Ø D <sub>s</sub>	8 mm
Overall length L	91 mm
Standard	DIN 6537
recommended maximum drilling depth L <sub>2</sub>	42.8 mm
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	6×D
Point angle	140 degrees
Shank	DIN 6535 HA to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Semi-Standard	yes
Colour ring	green
Type of product	Jobber drill

## Services

Shank grinding Type HE	129100 HE
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