

Garant

Solid carbide HPC drill plain shank DIN 6535 HA H7, TiAlN, Ø DC: 3,99 mm



Order data

Order number	122790 3,99
GTIN	4045197059000
Item class	11E

Description

Version:

Drilling and reaming in a single operation. Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry**. Particularly high alignment accuracy due to **4 guide chamfers**.

Advantage:

Very tight **manufacturing tolerances** with **H7 fit** can be produced without additional reaming.

Recommendation:

Maximum drilling depth:

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

Note:

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

Form **HB**: order with **No. 122790 + 129100HB** .

Form **HE**: order with **No. 122790 + 129100HE**.

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

Solid carbide precision fit drills for machining aluminium available on request.

Machining strategy: HPC

Bore Ø tolerance: H7

Standard: DIN 6537

Number of cutting edges Z: 2

Bore Ø tolerance: H7

recommended maximum drilling depth L_2 : 30.1 mm

Overall length L: 74 mm

Shank Ø D_s : 6 mm

Feed f in steel < 900 N/mm²: 0.12 mm/rev.

Technical description

Shank tolerance	h6
Nominal $\varnothing D_c$	3.99 mm
Feed f in steel < 900 N/mm ²	0.12 mm/rev.
Number of cutting edges Z	2
Flute length L_c	36 mm
Shank $\varnothing D_s$	6 mm
Overall length L	74 mm
Standard	DIN 6537
recommended maximum drilling depth L_2	30.1 mm
Bore \varnothing tolerance	H7
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
Colour ring	green
Type of product	Jobber drill

Services

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