Garant

Solid carbide HPC drill plain shank DIN 6535 HA H7, TiAIN, Ø DC: 6,02 mm



Order data

Order number	122790 6,02
GTIN	4045197059130
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 $1.5 \times nominal \emptyset$.

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 L₂: 35 mm

Overall length L: 82 mm

Shank Ø D_s: 6 mm

Feed f in steel < 900 N/mm²: 0.16 mm/rev.

Technical description

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Number of cutting edges Z2Nominal Ø Dc6.02 mmFlute length Lc44 mmShank toleranceh6Shank Ø Ds6 mmOverall length L82 mmStandardDIN 6537recommended maximum drilling depth L235 mmBore Ø toleranceH7CoatingTiAINTool materialSolid carbideDrill depth up to6×DPoint angle140 degreesShankDIN 6535 HA to h6Through-coolantyes, with 25 barMachining strategyHPCColour ringJobber drill	Feed f in steel < 900 N/mm ²	0.16 mm/rev.
Flute length L,44 mmShank toleranceh6Shank Ø D,6 mmOverall length L82 mmStandardDIN 6537recommended maximum drilling depth L235 mmBore Ø toleranceH7CoatingSolid carbideTool materialSolid carbideDrill depth up to6×DPoint angle140 degreesShankDIN 6535 HA to h6Through-coolantyes, with 25 barMachining strategyHPCColour ringgreen	Number of cutting edges Z	2
Shank toleranceh6Shank Ø Ds6 mmOverall length L82 mmStandardDIN 6537recommended maximum drilling depth L235 mmBore Ø toleranceH7CoatingTiAINTool materialSolid carbideDrill depth up to6×DPoint angle140 degreesShankDIN 6535 HA to h6Through-coolantyes, with 25 barMachining strategyHPCColour ringgreen	Nominal Ø D _c	6.02 mm
Shank Ø D,6 mmOverall length L82 mmStandardDIN 6537recommended maximum drilling depth L235 mmBore Ø toleranceH7CoatingTiAINTool materialSolid carbideDrill depth up to6×DPoint angle140 degreesShankDIN 6535 HA to h6Through-coolantyes, with 25 barMachining strategyHPCColour ringgreen	Flute length L _c	44 mm
Overall length L82 mmStandardDIN 6537recommended maximum drilling depth L235 mmBore Ø toleranceH7CoatingTiAINTool materialSolid carbideDrill depth up to6×DPoint angle140 degreesShankDIN 6535 HA to h6Through-coolantyes, with 25 barMachining strategyHPCColour ringgreen	Shank tolerance	h6
StandardDIN 6537recommended maximum drilling depth L235 mmBore Ø toleranceH7CoatingTiAINTool materialSolid carbideDrill depth up to6×DPoint angle140 degreesShankDIN 6535 HA to h6Through-coolantyes, with 25 barMachining strategyHPCColour ringgreen	Shank Ø D _s	6 mm
recommended maximum drilling depth L ₂ 35 mm Bore Ø tolerance H7 Coating TiAIN 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	Overall length L	82 mm
Bore Ø toleranceH7CoatingTiAINTool materialSolid carbideDrill depth up to6×DPoint angle140 degreesShankDIN 6535 HA to h6Through-coolantyes, with 25 barMachining strategyHPCColour ringgreen	Standard	DIN 6537
CoatingTiAINTool materialSolid carbideDrill depth up to6×DPoint angle140 degreesShankDIN 6535 HA to h6Through-coolantyes, with 25 barMachining strategyHPCColour ringgreen	recommended maximum drilling depth L_2	35 mm
Tool materialSolid carbideDrill depth up to6×DPoint angle140 degreesShankDIN 6535 HA to h6Through-coolantyes, with 25 barMachining strategyHPCColour ringgreen	Bore Ø tolerance	H7
Drill depth up to6×DPoint angle140 degreesShankDIN 6535 HA to h6Through-coolantyes, with 25 barMachining strategyHPCColour ringgreen	Coating	TiAIN
Point angle140 degreesShankDIN 6535 HA to h6Through-coolantyes, with 25 barMachining strategyHPCColour ringgreen	Tool material	Solid carbide
ShankDIN 6535 HA to h6Through-coolantyes, with 25 barMachining strategyHPCColour ringgreen	Drill depth up to	6×D
Through-coolantyes, with 25 barMachining strategyHPCColour ringgreen	Point angle	140 degrees
Machining strategyHPCColour ringgreen	Shank	DIN 6535 HA to h6
Colour ring green	Through-coolant	yes, with 25 bar
	Machining strategy	HPC
Type of product Jobber drill	Colour ring	green
	Type of product	Jobber drill

Services

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