Garant

# Solid carbide HPC drill plain shank DIN 6535 HA H7, TiAlN, ∅ DC: 9,98 mm

## Order data

| | |
|---|---|
| Order number | 122790 9,98 |
| GTIN | 4045197059192 |
| 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 ∅.
**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 ∅ tolerance: H7
Standard: DIN 6537
Number of cutting edges Z: 2
Bore ∅ tolerance: H7
recommended maximum drilling depth $L_2$: 46.1 mm
Overall length L: 103 mm
Shank ∅ $D_s$: 10 mm
Feed f in steel < 900 N/mm$^2$: 0.28 mm/rev.

## Technical description

| | |
|---|---|
| Nominal ⌀ $D_C$ | 9.98 mm |
| Feed f in steel < 900 N/mm$^2$ | 0.28 mm/rev. |
| Shank tolerance | h6 |
| Flute length $L_c$ | 61 mm |
| Number of cutting edges Z | 2 |
| Shank ⌀ $D_s$ | 10 mm |
| Overall length L | 103 mm |
| Standard | DIN 6537 |
| recommended maximum drilling depth $L_2$ | 46.1 mm |
| Bore ⌀ 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 |