

## Garant

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



#### Order data

Order number	122790 9H7
GTIN	4045197745507
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  $L_2$ : 47.5 mm

Overall length L: 103 mm

Shank Ø  $D_s$ : 10 mm

Feed f in steel  $< 900 \text{ N/mm}^2$ : 0.28 mm/rev.

#### Technical description

Shank tolerance	h6
Number of cutting edges Z	2
Flute length $L_c$	61 mm
Shank $\varnothing D_s$	10 mm
Standard	DIN 6537
Feed f in steel < 900 N/mm <sup>2</sup>	0.28 mm/rev.
Nominal $\varnothing D_c$	9 mm
Overall length L	103 mm
recommended maximum drilling depth $L_2$	47.5 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 HB	129100 HB
Shank grinding Type HE	129100 HE