

Garant
Solid carbide special drill DIN 6535 HA, uncoated, Ø DC ±0.003: 6,8mm

Order data

Order number	121201 6,8
GTIN	4062406089306
Item class	11E

Description
Version:

Spiral flute precision drill for plastics. **Self-centring** with **1-cutter geometry**, achieves **very high alignment accuracy**. **Polished** helical flutes for **optimum chip evacuation**.

Maintains the **tolerance band IT7** from entry Ø through to exit Ø, **due to special point geometry**.

Note:

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

HB and HE shanks are available at the same price as HA.

For **HB shanks**: use order **No. 121201 + 129100HB**.

For **HE shanks**: use order **No. 121201 + 129100HE**.

Technical description

Feed f in PEEK	0.2 mm/rev.
Shank Ø D _s	8 mm
Tolerance nominal Ø	±0.003
Flute length L _c	53 mm
Number of cutting edges Z	1
Shank tolerance	h6
Overall length L	91 mm
recommended maximum drilling depth L ₂	42.8 mm
Nominal Ø D _c	6.8 mm
Standard	Manufacturer's standard

Coating	uncoated
Tool material	Solid carbide
Version	5xD
Point angle	120 degrees
Shank	DIN 6535 HA to h6
Through-coolant	no
Semi-Standard	yes
Colour ring	without
Type of product	Jobber drill

User data

	Suitability	V _c	ISO code
PMMA acrylic	suitable	30 m/min	N
PE-HD	suitable	50 m/min	N
PA 66	suitable	50 m/min	N
PEEK	suitable	50 m/min	N
PF 31	suitable	50 m/min	N
PVDF GF20	suitable only under restricted conditions	60 m/min	N
POM GF25	suitable only under restricted conditions	60 m/min	N
PA 66 GF30	suitable only under restricted conditions	60 m/min	N
PEEK GF30	suitable only under restricted conditions	50 m/min	N
PTFE CF25	suitable only under restricted conditions	40 m/min	N
PEEK CF30	suitable only under restricted conditions	40 m/min	N
wet maximum	suitable only under restricted conditions		

dry	suitable
Air	suitable
Services	

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