

Garant
Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC h7: 8,9mm

Order data

| | |
|--------------|------------|
| Order number | 122690 8,9 |
| GTIN | |
| Item class | 11E |

Description
Version:

3 guide chamfers for particularly high accuracy and surface quality at tight hole tolerances.
Asymmetrical tip geometry for **very high metal removal rates**. New generation of **innovative high-performance drills for cast iron** in the HPC field.

Advantage:

For HPC high performance drilling in castings. **Outstandingly suitable for bainite cast iron (ADI)**.

Note:

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

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

Form **HB**: order with **No. 122690 + 129100HB** .

Form **HE**: order with **No. 122690 + 129100HE**.

Technical description

| | |
|---|--------------|
| Standard | DIN 6537 |
| recommended maximum drilling depth L_2 | 47.7 mm |
| Overall length L | 103 mm |
| Flute length L_c | 61 mm |
| Tolerance nominal Ø | h7 |
| Number of cutting edges Z | 2 |
| Nominal Ø D_c | 8.9 mm |
| Feed f in GJS ADI > 800 N/mm ² | 0.29 mm/rev. |

| | |
|-------------------------|-------------------|
| Shank $\varnothing D_s$ | 10 mm |
| Coating | TiAlN |
| Tool material | Solid carbide |
| Version | 6xD |
| Point angle | 135 ° |
| Shank | DIN 6535 HA to h6 |
| Through-coolant | yes, with 25 bar |
| Machining strategy | HPC |
| Semi-Standard | yes |
| Colour ring | white |
| Type of product | Jobber drill |

User data

| | Suitability | V_c | ISO code |
|---------------------------------|-------------|-----------|----------|
| GG | suitable | 110 m/min | K |
| GGG | suitable | 90 m/min | K |
| GJS, ADI > 800N/mm ² | suitable | 70 m/min | K |
| wet maximum | suitable | | |
| wet minimum | suitable | | |

Services

| | |
|------------------------|-----------|
| Shank grinding Type HE | 129100 HE |
| Shank grinding Type HB | 129100 HB |