

**Garant**
**Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC h7: 3,6mm**

**Order data**

Order number	122690 3,6
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**

Shank Ø D <sub>s</sub>	6 mm
Nominal Ø D <sub>c</sub>	3.6 mm
Overall length L	66 mm
Number of cutting edges Z	2
Standard	DIN 6537
recommended maximum drilling depth L <sub>2</sub>	22.6 mm
Tolerance nominal Ø	h7
Shank tolerance	h6

Flute length $L_c$	28 mm
Feed $f$ in GJS ADI $> 800 \text{ N/mm}^2$	0.16 mm/rev.
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 $> 800 \text{ N/mm}^2$	suitable	70 m/min	K
wet maximum	suitable		
wet minimum	suitable		

## Services

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