

**Garant**
**Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC h7: 8,2mm**

**Order data**

|              |            |
|--------------|------------|
| Order number | 122690 8,2 |
| 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     |
| Shank Ø D <sub>s</sub>                            | 10 mm        |
| Nominal Ø D <sub>c</sub>                          | 8.2 mm       |
| Overall length L                                  | 103 mm       |
| recommended maximum drilling depth L <sub>2</sub> | 48.7 mm      |
| Tolerance nominal Ø                               | h7           |
| Number of cutting edges Z                         | 2            |
| Feed f in GJS ADI > 800 N/mm <sup>2</sup>         | 0.29 mm/rev. |

|                    |                   |
|--------------------|-------------------|
| Flute length $L_c$ | 61 mm             |
| Coating            | TiAlN             |
| Tool material      | Solid carbide     |
| Version            | 6×D               |
| 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 <sup>2</sup> | suitable    | 70 m/min  | K        |
| wet maximum                     | suitable    |           |          |
| wet minimum                     | suitable    |           |          |

## Services

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