

Garant
Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC h7: 18,5mm

Order data

Order number	122690 18,5
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

recommended maximum drilling depth L_2	73.3 mm
Tolerance nominal \varnothing	h7
Flute length L_c	101 mm
Feed f in GJS ADI $> 800 \text{ N/mm}^2$	0.46 mm/rev.
Overall length L	153 mm
Number of cutting edges Z	2
Standard	DIN 6537
Nominal $\varnothing D_c$	18.5 mm

Shank $\varnothing D_s$	20 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 HB	129100 HB
Shank grinding Type HE	129100 HE