

**Garant**
**Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC h7: 3,9mm**

**Order data**

|              |            |
|--------------|------------|
| Order number | 122690 3,9 |
| 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**

|   |              |
|---|--------------|
| Number of cutting edges Z                 | 2            |
| Standard                                  | DIN 6537     |
| Flute length $L_c$                        | 36 mm        |
| Shank tolerance                           | h6           |
| Tolerance nominal Ø                       | h7           |
| Nominal Ø $D_c$                           | 3.9 mm       |
| Feed f in GJS ADI > 800 N/mm <sup>2</sup> | 0.16 mm/rev. |
| Overall length L                          | 74 mm        |

|   |                   |
|---|-------------------|
| Shank Ø D <sub>s</sub>                            | 6 mm              |
| recommended maximum drilling depth L <sub>2</sub> | 30.2 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 <sub>c</sub> | 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 HE | 129100 HE |
| Shank grinding Type HB | 129100 HB |