

## Garant

### Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC h7: 5,7mm



#### Order data

|              |            |
|--------------|------------|
| Order number | 122690 5,7 |
| 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

|   |              |
|---|--------------|
| Feed f in GJS ADI > 800 N/mm <sup>2</sup> | 0.22 mm/rev. |
| Flute length $L_c$                        | 44 mm        |
| Standard                                  | DIN 6537     |
| recommended maximum drilling depth $L_2$  | 35.5 mm      |
| Shank Ø $D_s$                             | 6 mm         |
| Nominal Ø $D_c$                           | 5.7 mm       |
| Tolerance nominal Ø                       | h7           |
| Overall length L                          | 82 mm        |

|                           |                   |
|---------------------------|-------------------|
| Shank tolerance           | h6                |
| Number of cutting edges Z | 2                 |
| 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 HB | 129100 HB |
| Shank grinding Type HE | 129100 HE |