

## Garant

**Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC m6 (Ø DC X = h7)  
(mm or inch): 8,15**



### Order data

|              |               |
|--------------|---------------|
| Order number | 122659 8,15   |
| GTIN         | 4045197743633 |
| Item class   | 11E           |

### Description

#### Version:

Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry**. High roundness and alignment accuracy of the deep hole, thanks to **4 guide chamfers**. Outstanding chip evacuation due to **4 internal cooling channels** from Ø 3.8 mm. Up to 3.7 mm Ø with 2 internal cooling channels. **Straight major cutting edges** with honed edges and special flute profile for **short chips**, even on long chipping materials.

#### Attention:

Sizes **ending with X** = cutter Ø tolerance **h7**.

#### 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. 122661**.

Form **HE**: order with **No. 122659 + 129100HE**.

Standard: DIN 6537

Tolerance nominal Ø: m6

Number of cutting edges Z: 2

recommended maximum drilling depth  $L_2$ : 48.8 mm

Tolerance nominal Ø: m6

Overall length L: 103 mm

Shank Ø  $D_s$ : 10 mm

Feed f in stainless steel > 900 N/mm<sup>2</sup>: 0.15 mm/rev.

### Technical description

|                    |       |
|--------------------|-------|
| Flute length $L_c$ | 61 mm |
|--------------------|-------|

|   |                   |
|---|-------------------|
| Feed f in stainless steel > 900 N/mm <sup>2</sup> | 0.15 mm/rev.      |
| Standard  | DIN 6537          |
| Number of cutting edges Z                         | 2                 |
| Shank Ø D <sub>s</sub>                            | 10 mm             |
| Tolerance nominal Ø                               | m6                |
| Overall length L                                  | 103 mm            |
| Shank tolerance                                   | h6                |
| Nominal Ø D <sub>c</sub>                          | 8.15 mm           |
| recommended maximum drilling depth L <sub>2</sub> | 48.8 mm           |
| Coating   | TiAlN             |
| Tool material                                     | Solid carbide     |
| Version   | 6×D               |
| Point angle                                       | 140°              |
| Shank   | DIN 6535 HA to h6 |
| Through-coolant                                   | yes, with 25 bar  |
| Machining strategy                                | HPC               |
| Semi-Standard                                     | yes               |
| Colour ring                                       | blue              |
| Type of product                                   | Jobber drill      |

## User data

|                                | Suitability | V <sub>c</sub> | ISO code |
|--------------------------------|-------------|----------------|----------|
| Steel < 500 N/mm <sup>2</sup>  | suitable    | 170 m/min      | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable    | 140 m/min      | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable    | 130 m/min      | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable    | 110 m/min      | P        |
| Steel < 1400 N/mm <sup>2</sup> | suitable    | 70 m/min       | P        |
| INOX < 900 N/mm <sup>2</sup>   | suitable    | 90 m/min       | M        |
| INOX > 900 N/mm <sup>2</sup>   | suitable    | 80 m/min       | M        |

|             |          |          |   |
|-------------|----------|----------|---|
| GG(G)       | suitable | 95 m/min | K |
| wet maximum | suitable |          |   |
| wet minimum | suitable |          |   |
| Air         | suitable |          |   |

**Services**

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