

**Garant****Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC h7: 6,7mm****Order data**

|              |               |
|--------------|---------------|
| Order number | 123110 6,7    |
| GTIN         | 4045197357526 |
| Item class   | 11E           |

**Description****Version:**

Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry**.

Particularly high alignment accuracy due to **4 guide chamfers** which stabilise the drill even at extreme depths!

**Straight major cutting edges** with honed edges and special flute profile for **short chips**, even on long chipping materials.

**Advantage:**

**High process reliability and surface quality of the hole.**

**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. 123115**.

Form **HE**: order with **No. 123110 + 129100 HE**.

**Technical description**

|   |              |
|---|--------------|
| Nominal Ø $D_c$                                   | 6.7 mm       |
| Number of cutting edges Z                         | 2            |
| Shank tolerance                                   | h6           |
| Flute length $L_c$                                | 75 mm        |
| Feed f in stainless steel < 900 N/mm <sup>2</sup> | 0.12 mm/rev. |
| Tolerance nominal Ø                               | h7           |
| Shank Ø $D_s$                                     | 8 mm         |

|   |                         |
|---|-------------------------|
| Overall length L                                  | 114 mm                  |
| Standard  | Manufacturer's standard |
| recommended maximum drilling depth L <sub>2</sub> | 65 mm                   |
| Coating   | TiAlN                   |
| Tool material                                     | Solid carbide           |
| Version   | 10×D                    |
| Point angle                                       | 135 degrees             |
| 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

|                               | <b>Suitability</b>                        | <b>V<sub>c</sub></b> | <b>ISO code</b> |
|-------------------------------|---|----------------------|-----------------|
| Aluminium (short chipping)    | suitable only under restricted conditions | 200 m/min            | N               |
| Alu > 10% Si                  | suitable only under restricted conditions | 180 m/min            | N               |
| Steel < 500 N/mm <sup>2</sup> | suitable                                  | 110 m/min            | P               |
| Steel < 750 N/mm <sup>2</sup> | suitable                                  | 80 m/min             | P               |
| Steel < 900 N/mm <sup>2</sup> | suitable                                  | 70 m/min             | P               |
| INOX < 900 N/mm <sup>2</sup>  | suitable                                  | 65 m/min             | M               |
| INOX > 900 N/mm <sup>2</sup>  | suitable                                  | 55 m/min             | M               |
| Ti > 850 N/mm <sup>2</sup>    | suitable                                  | 25 m/min             | S               |
| wet maximum                   | suitable                                  |                      |                 |
| wet minimum                   | suitable                                  |                      |                 |

## Services

Shank grinding Type HE

129100 HE