ᵼᴏ Hoffmann Group

Garant

Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC m6 (Ø DC X = h7) (mm or inch): 2,02X

Order data

Order number	122659 2,02X
GTIN	4045197646606
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: h7
Number of cutting edges Z: 2
Tolerance nominal Ø: h7
Overall length L: 57 mm
Shank Ø D_s: 4 mm
Feed f in stainless steel > 900 N/mm^2: 0.05 mm/rev.

Technical description

Shank tolerance	h6
Feed f in stainless steel > 900 N/mm^2	0.05 mm/rev.

Flute length L_c	21 mm
Nominal Ø D_c	2.02 mm
Number of cutting edges Z	2
Tolerance nominal Ø	h7
Shank Ø D_s	4 mm
Overall length L	57 mm
Standard	DIN 6537
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_c**	**ISO code**
Steel < 500 N/mm²	suitable	170 m/min	P
Steel < 750 N/mm²	suitable	140 m/min	P
Steel < 900 N/mm²	suitable	130 m/min	P
Steel < 1100 N/mm²	suitable	110 m/min	P
Steel < 1400 N/mm²	suitable	70 m/min	P
INOX < 900 N/mm²	suitable	90 m/min	M
INOX > 900 N/mm²	suitable	80 m/min	M
GG(G)	suitable	95 m/min	K
wet maximum	suitable		

wet minimum	suitable
Air	suitable