

## Garant

### Solid carbide HPC drill, plain shank DIN 6535 HA, DLC, Ø DC h7: 6,6mm



#### Order data

|              |               |
|--------------|---------------|
| Order number | 122808 6,6    |
| GTIN         | 4045197754004 |
| Item class   | 11E           |

#### Description

##### Version:

**DLC coating  $sp^2$**  of the latest generation with **low coefficient of friction** results in **outstanding chip clearance**. For **high-performance milling** of **aluminium materials**. **High roundness** and **alignment accuracy of the deep hole**, thanks to **6 guide chamfers**.

##### 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. 122809**.

Form **HE**: order with **No. 122808 + 129100HE**.

#### Technical description

|  |                         |
|--|-------------------------|
| Shank Ø $D_s$                            | 8 mm                    |
| Flute length $L_c$                       | 76 mm                   |
| Overall length $L$                       | 114 mm                  |
| Standard                                 | Manufacturer's standard |
| Shank tolerance                          | h6                      |
| Nominal Ø $D_c$                          | 6.6 mm                  |
| Number of cutting edges $Z$              | 2                       |
| Feed $f$ in aluminium short-chipping     | 0.45 mm/rev.            |
| Tolerance nominal Ø                      | h7                      |
| recommended maximum drilling depth $L_2$ | 66.1 mm                 |

|                    |                   |
|--------------------|-------------------|
| Coating            | DLC               |
| Tool material      | solid carbide     |
| Version            | 8xD               |
| Type               | W                 |
| Point angle        | 135 degrees       |
| Shank              | DIN 6535 HA to h6 |
| Through-coolant    | yes, with 25 bar  |
| Machining strategy | HPC               |
| Semi-Standard      | yes               |
| Colour ring        | yellow            |
| Type of product    | Jobber drill      |

## User data

|                            | Suitability | V <sub>c</sub> | ISO code |
|----------------------------|-------------|----------------|----------|
| Alu plastics               | suitable    | 325 m/min      | N        |
| Aluminium (short chipping) | suitable    | 360 m/min      | N        |
| Alu > 10% Si               | suitable    | 315 m/min      | N        |
| PMMA acrylic               | suitable    | 135 m/min      | N        |
| PEEK                       | suitable    | 110 m/min      | N        |
| PVDF GF20                  | suitable    | 80 m/min       | N        |
| PA 66 GF30                 | suitable    | 70 m/min       | N        |
| PEEK GF30                  | suitable    | 60 m/min       | N        |
| PTFE CF25                  | suitable    | 70 m/min       | N        |
| Cu                         | suitable    | 140 m/min      | N        |
| CuZn                       | suitable    | 160 m/min      | N        |
| GRP                        | suitable    | 70 m/min       | N        |
| CRP                        | suitable    | 70 m/min       | N        |
| wet maximum                | suitable    |                |          |

wet minimum  
**Services**

suitable

Shank grinding Type HE

129100 HE