

Garant
Solid carbide HPC drill, plain shank DIN 6535 HA, DLC, Ø DC h7: 13,5mm


Order data

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|--------------|---------------|
| Order number | 122306 13,5 |
| GTIN | 4045197751898 |
| 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 alignment accuracy** and **roundness of the hole**, thanks to **6 guide chamfers**.

Size 1 - 1.5 with 4 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. 122307**.

Form **HE**: order with **No. 122306 + 129100HE**.

Technical description

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|------------------------------------|--------------|
| Shank tolerance | h6 |
| Overall length L | 107 mm |
| Flute length L_c | 60 mm |
| Feed f in aluminium short-chipping | 0.65 mm/rev. |
| Standard | DIN 6537 K |
| Shank $\varnothing D_s$ | 14 mm |
| Tolerance nominal \varnothing | h7 |
| Number of cutting edges Z | 2 |
| Nominal $\varnothing D_c$ | 13.5 mm |

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|---|-------------------|
| recommended maximum drilling depth L ₂ | 39.8 mm |
| Coating | DLC |
| Tool material | solid carbide |
| Version | 4xD |
| 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 _c | ISO code |
|----------------------------|-------------|----------------|----------|
| Alu plastics | suitable | 360 m/min | N |
| Aluminium (short chipping) | suitable | 400 m/min | N |
| Alu > 10% Si | suitable | 350 m/min | N |
| PMMA acrylic | suitable | 150 m/min | N |
| PEEK | suitable | 120 m/min | N |
| PVDF GF20 | suitable | 90 m/min | N |
| PA 66 GF30 | suitable | 80 m/min | N |
| PEEK GF30 | suitable | 70 m/min | N |
| PTFE CF25 | suitable | 80 m/min | N |
| Cu | suitable | 160 m/min | N |
| CuZn | suitable | 200 m/min | N |
| GRP | suitable | 80 m/min | N |
| CRP | suitable | 80 m/min | N |

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|-------------|----------|
| wet maximum | suitable |
| wet minimum | suitable |

Services

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