

**Garant**
**Solid carbide HPC drill, plain shank DIN 6535 HA, DLC, Ø DC h7: 6,9mm**


## Order data

Order number	122306 6,9
GTIN	4045197751478
Item class	11E

## Description

### Version:

**DLC coating sp<sup>2</sup>** 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

Standard	DIN 6537 K
Shank tolerance	h6
Number of cutting edges Z	2
Nominal Ø D <sub>c</sub>	6.9 mm
Shank Ø D <sub>s</sub>	8 mm
Overall length L	79 mm
Flute length L <sub>c</sub>	34 mm
Feed f in aluminium short-chipping	0.45 mm/rev.
Tolerance nominal Ø	h7

recommended maximum drilling depth L <sub>2</sub>	23.7 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 <sub>c</sub>	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

wet maximum	suitable
wet minimum	suitable

**Services**

Shank grinding Type HE	129100 HE
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