

**Garant**
**Solid carbide HPC drill, plain shank DIN 6535 HA, DLC, Ø DC h7: 7,1mm**


## Order data

|              |               |
|--------------|---------------|
| Order number | 122306 7,1    |
| GTIN         | 4045197751492 |
| 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

|                                      |              |
|--------------------------------------|--------------|
| Shank Ø $D_s$                        | 8 mm         |
| Standard                             | DIN 6537 K   |
| Flute length $L_c$                   | 41 mm        |
| Feed $f$ in aluminium short-chipping | 0.45 mm/rev. |
| Number of cutting edges $Z$          | 2            |
| Nominal Ø $D_c$                      | 7.1 mm       |
| Shank tolerance                      | h6           |
| Tolerance nominal Ø                  | h7           |
| Overall length $L$                   | 79 mm        |

|   |                   |
|---|-------------------|
| recommended maximum drilling depth L <sub>2</sub> | 30.4 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 |
|------------------------|-----------|