Garant

Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, ∅ DC m6 (∅ DC X = h7) (mm or inch): 7,7

Order data

Order number	122659 7,7
GTIN	4045197456205
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 ∅ 3.8 mm. Up to 3.7 mm ∅ 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 ∅ 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 ∅: m6
Number of cutting edges Z: 2
recommended maximum drilling depth L_2: 41.5 mm
Tolerance nominal ∅: m6
Overall length L: 91 mm
Shank ∅ D_s: 8 mm
Feed f in stainless steel > 900 N/mm^2: 0.12 mm/rev.

Technical description

Shank tolerance	h6
Number of cutting edges Z	2

Flute length L_c	53 mm
Nominal ⌀ D_C	7.7 mm
Feed f in stainless steel > 900 N/mm²	0.12 mm/rev.
Tolerance nominal ⌀	m6
Shank ⌀ D_s	8 mm
Overall length L	91 mm
Standard	DIN 6537
recommended maximum drilling depth L_2	41.5 mm
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

Services

Shank grinding Type HE	129100 HE