

Garant

**Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC m6 (Ø DC X = h7)
(mm or inch): 13,8**



Order data

| | |
|--------------|---------------|
| Order number | 122659 13,8 |
| GTIN | 4045197456588 |
| 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 Ø 3.8 mm. Up to 3.7 mm Ø 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 Ø 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 Ø: m6

Number of cutting edges Z: 2

recommended maximum drilling depth L_2 : 56.3 mm

Tolerance nominal Ø: m6

Overall length L: 124 mm

Shank Ø D_s : 14 mm

Feed f in stainless steel > 900 N/mm²: 0.2 mm/rev.

Technical description

| | |
|---|-------------|
| Feed f in stainless steel > 900 N/mm ² | 0.2 mm/rev. |
| Number of cutting edges Z | 2 |

| | |
|--|-------------------|
| Shank tolerance | h6 |
| Nominal $\varnothing D_c$ | 13.8 mm |
| Flute length L_c | 77 mm |
| Tolerance nominal \varnothing | m6 |
| Shank $\varnothing D_s$ | 14 mm |
| Overall length L | 124 mm |
| Standard | DIN 6537 |
| recommended maximum drilling depth L_2 | 56.3 mm |
| Coating | TiAlN |
| Tool material | Solid carbide |
| Version | 6xD |
| 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/mm ² | suitable | 170 m/min | P |
| Steel < 750 N/mm ² | suitable | 140 m/min | P |
| Steel < 900 N/mm ² | suitable | 130 m/min | P |
| Steel < 1100 N/mm ² | suitable | 110 m/min | P |
| Steel < 1400 N/mm ² | suitable | 70 m/min | P |
| INOX < 900 N/mm ² | suitable | 90 m/min | M |
| INOX > 900 N/mm ² | 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 |