

Garant**Solid carbide HPC drill type FS plain shank DIN 6535 HA, TiAlN, Ø DC h7: 16 mm****Order data**

Order number	122670 16
GTIN	4045197057143
Item class	11E

Description**Version:**

Particularly strong due to strengthened core and **special profile**. Special point geometry.

High concentricity and **long tool life**.

High bore quality.

Recommendation:**Maximum drilling depth:**

flute length (see table) less 1.5×nominal Ø.

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. 122675**.

Form **HE**: order with **No. 122670 + 129100HE**.

Standard: DIN 6537

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

Tolerance nominal Ø: h7

recommended maximum drilling depth L_2 : 59 mm

Overall length L: 133 mm

Shank Ø D_s : 16 mm

Feed f in titanium > 850 N/mm²: 0.16 mm/rev.

Technical description

Shank tolerance	h6
Number of cutting edges Z	2

Flute length L_c	83 mm
Feed f in titanium $> 850 \text{ N/mm}^2$	0.16 mm/rev.
Nominal $\varnothing D_c$	16 mm
Tolerance nominal $\varnothing$	h7
Shank $\varnothing D_s$	16 mm
Overall length L	133 mm
Standard	DIN 6537
recommended maximum drilling depth L_2	59 mm
Coating	TiAlN
Tool material	Solid carbide
	6×D
Type	FS
Point angle	140 °
Shank	DIN 6535 HA to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Semi-Standard	yes
Colour ring	pink
Type of product	Jobber drill

User data

	Suitability	V_c	ISO code
Alu plastics	suitable	260 m/min	N
Aluminium (short chipping)	suitable	240 m/min	N
Alu $> 10\% \text{ Si}$	suitable	160 m/min	N
Steel $< 500 \text{ N/mm}^2$	suitable	110 m/min	P
Steel $< 750 \text{ N/mm}^2$	suitable	90 m/min	P
Steel $< 900 \text{ N/mm}^2$	suitable	85 m/min	P

Steel < 1100 N/mm ²	suitable	60 m/min	P
Steel < 1400 N/mm ²	suitable only under restricted conditions	30 m/min	P
INOX < 900 N/mm ²	suitable	40 m/min	M
INOX > 900 N/mm ²	suitable	35 m/min	M
Ti > 850 N/mm ²	suitable	35 m/min	S
wet maximum	suitable		
wet minimum	suitable		
Air	suitable		

Services

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