

**Garant**

**Solid carbide HPC drill type FS plain shank DIN 6535 HA, TiAlN, Ø DC h7: 7,9 mm**


**Order data**

|              |               |
|--------------|---------------|
| Order number | 122670 7,9    |
| GTIN         | 4045197056702 |
| 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  $L_2$ : 41.2 mm

Overall length L: 91 mm

Shank Ø  $D_s$ : 8 mm

Feed f in titanium > 850 N/mm<sup>2</sup>: 0.08 mm/rev.

**Technical description**

|                                            |              |
|--------------------------------------------|--------------|
| Feed f in titanium > 850 N/mm <sup>2</sup> | 0.08 mm/rev. |
| Number of cutting edges Z                  | 2            |

|                                                   |                   |
|---------------------------------------------------|-------------------|
| Nominal Ø D <sub>c</sub>                          | 7.9 mm            |
| Flute length L <sub>c</sub>                       | 53 mm             |
| Shank tolerance                                   | h6                |
| Tolerance nominal Ø                               | h7                |
| Shank Ø D <sub>s</sub>                            | 8 mm              |
| Overall length L                                  | 91 mm             |
| Standard                                          | DIN 6537          |
| recommended maximum drilling depth L <sub>2</sub> | 41.2 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 <sub>c</sub> | ISO code |
|-------------------------------|-------------|----------------|----------|
| Alu plastics                  | suitable    | 260 m/min      | N        |
| Aluminium (short chipping)    | suitable    | 240 m/min      | N        |
| Alu > 10% Si                  | suitable    | 160 m/min      | N        |
| Steel < 500 N/mm <sup>2</sup> | suitable    | 110 m/min      | P        |
| Steel < 750 N/mm <sup>2</sup> | suitable    | 90 m/min       | P        |
| Steel < 900 N/mm <sup>2</sup> | suitable    | 85 m/min       | P        |

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

### Services

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