

Garant

Solid carbide HPC drill type FS plain shank DIN 6535 HA, TiAlN, Ø DC h7: 18,5 mm

**Order data**

Order number	122670 18,5
GTIN	4045197057198
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 $1.5 \times \text{nominal } \varnothing$.

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 $\varnothing$: h7

Number of cutting edges Z: 2

Tolerance nominal $\varnothing$: h7

recommended maximum drilling depth L_2 : 73.3 mm

Overall length L: 153 mm

Shank $\varnothing D_s$: 20 mm

Feed f in titanium $> 850 \text{ N/mm}^2$: 0.2 mm/rev.

Technical description

Nominal $\varnothing D_c$	18.5 mm
Number of cutting edges Z	2

Shank tolerance	h6
Feed f in titanium > 850 N/mm ²	0.2 mm/rev.
Flute length L _c	101 mm
Tolerance nominal Ø	h7
Shank Ø D _s	20 mm
Overall length L	153 mm
Standard	DIN 6537
recommended maximum drilling depth L ₂	73.3 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% Si	suitable	160 m/min	N
Steel < 500 N/mm ²	suitable	110 m/min	P
Steel < 750 N/mm ²	suitable	90 m/min	P
Steel < 900 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