

## Garant

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



#### Order data

Order number	122670 9,7
GTIN	4045197056887
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  $L_2$ : 46.5 mm

Overall length L: 103 mm

Shank  $\varnothing D_s$ : 10 mm

Feed f in titanium  $> 850 \text{ N/mm}^2$ : 0.12 mm/rev.

#### Technical description

Number of cutting edges Z	2
Feed f in titanium $> 850 \text{ N/mm}^2$	0.12 mm/rev.

Shank tolerance	h6
Nominal $\varnothing D_c$	9.7 mm
Flute length $L_c$	61 mm
Tolerance nominal $\varnothing$	h7
Shank $\varnothing D_s$	10 mm
Overall length L	103 mm
Standard	DIN 6537
recommended maximum drilling depth $L_2$	46.5 mm
Coating	TiAlN
Tool material	Solid carbide
	6xD
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 <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		
<b>Services</b>			

Shank grinding Type HE

129100 HE