

**Garant**
**Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC h7: 6,8mm**

**Order data**

Order number	122690 6,8
GTIN	4045197597083
Item class	11E

**Description**
**Version:**

**3 guide chamfers** for particularly high accuracy and surface quality at tight hole tolerances.  
**Asymmetrical tip geometry** for **very high metal removal rates**. New generation of **innovative high-performance drills for cast iron** in the HPC field.

**Advantage:**

For HPC high performance drilling in castings. **Outstandingly suitable for bainite cast iron (ADI)**.

**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. 122690 + 129100HB** .

Form **HE**: order with **No. 122690 + 129100HE**.

Standard: DIN 6537

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

recommended maximum drilling depth  $L_2$ : 42.8 mm

Tolerance nominal Ø: h7

Overall length L: 91 mm

Shank Ø  $D_s$ : 8 mm

Feed f in GJS ADI > 800 N/mm<sup>2</sup>: 0.22 mm/rev.

**Technical description**

Nominal Ø $D_c$	6.8 mm
Flute length $L_c$	53 mm
Shank tolerance	h6

Number of cutting edges Z	2
Feed f in GJS ADI > 800 N/mm <sup>2</sup>	0.22 mm/rev.
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>	42.8 mm
Coating	TiAlN
Tool material	Solid carbide
Version	6×D
Point angle	135°
Shank	DIN 6535 HA to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Semi-Standard	yes
Colour ring	white
Type of product	Jobber drill

## User data

	Suitability	V <sub>c</sub>	ISO code
GG	suitable	110 m/min	K
GGG	suitable	90 m/min	K
GJS, ADI > 800N/mm <sup>2</sup>	suitable	70 m/min	K
wet maximum	suitable		
wet minimum	suitable		

## Services

Shank grinding Type HE	129100 HE
Shank grinding Type HB	129100 HB

