

**Garant**
**Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC p6: 8,8mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 122736 8,8    |
| GTIN         | 4045197567222 |
| Item class   | 11E           |

**Description**
**Version:**

Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry**. High roundness and alignment accuracy of the deep hole, thanks to **4 guide chamfers**. Outstanding chip evacuation due to **4 internal cooling channels** from Ø 3.8 mm. Up to 3.7 mm Ø with 2 internal cooling channels. With **140° point angle** and special **j6 cutting edge tolerance** for optimum generation of a pilot hole.

**Note:**

Flute length  $L_c = L_2 + 1.5 \times D_c$ .

For deep-hole drilling deeper than 12×D a pilot hole is recommended, and for deep-hole drilling from 20×D to 30×D it is essential.

**The generation of a pilot hole improves process reliability.**

Form HB and HE supplied at the same price as HA.

Form **HB**: order with **No. 122738**.

Form **HE**: order with **No. 122736 + 129100HE**.

**Technical description**

|  |              |
|--|--------------|
| Feed f in steel < 1100 N/mm <sup>2</sup> | 0.27 mm/rev. |
| Nominal Ø D <sub>c</sub>                 | 8.8 mm       |
| Flute length L <sub>c</sub>              | 61 mm        |
| Shank tolerance                          | h6           |
| Number of cutting edges Z                | 2            |
| Tolerance nominal Ø                      | p6           |
| Shank Ø D <sub>s</sub>                   | 10 mm        |

|   |                   |
|---|-------------------|
| Overall length L                                  | 103 mm            |
| Standard  | DIN 6537          |
| recommended maximum drilling depth L <sub>2</sub> | 47.8 mm           |
| Coating   | TiAlN             |
| Tool material                                     | Solid carbide     |
| Version   | 6×D               |
| Point angle                                       | 140 degrees       |
| Shank   | DIN 6535 HA to h6 |
| Through-coolant                                   | yes, with 25 bar  |
| Machining strategy                                | HPC               |
| Semi-Standard                                     | yes               |
| Colour ring                                       | green             |
| Type of product                                   | Jobber drill      |

## User data

|                                | Suitability | V <sub>c</sub> | ISO code |
|--------------------------------|-------------|----------------|----------|
| Steel < 500 N/mm <sup>2</sup>  | suitable    | 170 m/min      | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable    | 130 m/min      | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable    | 120 m/min      | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable    | 110 m/min      | P        |
| Steel < 1400 N/mm <sup>2</sup> | suitable    | 65 m/min       | P        |
| INOX < 900 N/mm <sup>2</sup>   | suitable    | 75 m/min       | M        |
| INOX > 900 N/mm <sup>2</sup>   | suitable    | 70 m/min       | M        |
| GG(G)                          | suitable    | 95 m/min       | K        |
| Uni                            | suitable    |                |          |
| wet maximum                    | suitable    |                |          |
| wet minimum                    | suitable    |                |          |
| Air                            | suitable    |                |          |

## Services

Shank grinding Type HE

129100 HE