

**Garant**
**Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC h7: 3,9mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 122760 3,9    |
| GTIN         | 4045197057310 |
| Item class   | 11E           |

**Description**
**Version:**

Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry**.

**Convex cutting edges** with honed edges and special flute profile for **short chips**, even on long chipping materials.

**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. 122765**.

Form **HE**: order with **No. 122760 + 129100HE**.

**NEW GENERATION AVAILABLE!**

**Recommended successor products are No. 122715; 122725 and 122651.**

**Technical description**

|  |              |
|--|--------------|
| Number of cutting edges Z                | 2            |
| Flute length $L_c$                       | 36 mm        |
| Shank tolerance                          | h6           |
| Nominal $\varnothing D_c$                | 3.9 mm       |
| Feed f in steel < 1100 N/mm <sup>2</sup> | 0.11 mm/rev. |
| Tolerance nominal $\varnothing$          | h7           |
| Shank $\varnothing D_s$                  | 6 mm         |
| Overall length L                         | 74 mm        |

|   |                   |
|---|-------------------|
| Standard  | DIN 6537          |
| recommended maximum drilling depth L <sub>2</sub> | 30.2 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 only under restricted conditions | 120 m/min      | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable                                  | 100 m/min      | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable                                  | 85 m/min       | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable                                  | 65 m/min       | P        |
| Steel < 1400 N/mm <sup>2</sup> | suitable                                  | 35 m/min       | P        |
| Steel < 55 HRC                 | suitable                                  | 28 m/min       | H        |
| INOX < 900 N/mm <sup>2</sup>   | suitable only under restricted conditions | 30 m/min       | M        |
| Ti > 850 N/mm <sup>2</sup>     | suitable only under restricted conditions | 35 m/min       | S        |
| GG(G)                          | suitable                                  | 70 m/min       | K        |
| Uni                            | suitable                                  |                |          |
| wet maximum                    | suitable                                  |                |          |
| Air                            | suitable                                  |                |          |

## Services

Shank grinding Type HE

129100 HE