

## Garant

### Solid carbide drill plain shank for multi-directional fibre orientation DIN 6535 HA, Diamond, Ø DC m7: 1,5mm



#### Order data

Order number	122512 1,5
GTIN	4045197654229
Item class	11Y

#### Description

##### Version:

With the latest generation of **crystalline diamond coating sp<sup>3</sup>**, for process reliability in machining **fibre-reinforced composites, CRP, GRP, and graphite. With 90° point angle** and special geometry to **avoid delamination.**

**With guide chamfer** for materials with **multi-directional** fibre orientation.

##### Note:

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

Available in **1/100 sizes** and according to the table.

**Please note the minimum order quantities for configurable sizes:**

Ø range 1.01 – 2.99 mm: **10 pieces**

Ø range 3.01 – 9.99 mm: **5 pieces**

Ø range 10.01 – 11.99 mm: **3 pieces**

#### Technical description

Shank tolerance	h6
Number of cutting edges Z	2
Feed f in GRP CRP	0.02 mm/rev.
Flute length $L_c$	10.5 mm
Nominal Ø $D_c$	1.5 mm
Tolerance nominal Ø	m7
Shank Ø $D_s$	4 mm
Overall length L	50 mm

recommended maximum drilling depth L <sub>2</sub>	8.3 mm
Coating	Diamond
Tool material	Solid carbide
Standard	Manufacturer's standard
Version	5×D
Point angle	90 degrees
Shank	DIN 6535 HA to h6
Through-coolant	no
Colour ring	black
Type of product	Jobber drill

## User data

	Suitability	V <sub>c</sub>	ISO code
PMMA acrylic	suitable only under restricted conditions	150 m/min	N
PE-HD	suitable only under restricted conditions	140 m/min	N
PA 66	suitable only under restricted conditions	130 m/min	N
PEEK	suitable only under restricted conditions	120 m/min	N
PF 31	suitable only under restricted conditions	100 m/min	N
PVDF GF20	suitable	110 m/min	N
POM GF25	suitable	100 m/min	N
PA 66 GF30	suitable	90 m/min	N
PEEK GF30	suitable	80 m/min	N
PTFE CF25	suitable	90 m/min	N
PEEK CF30	suitable	80 m/min	N
Hybrids	suitable		

GRP, CRP	suitable	100 m/min	N
Graphite	suitable	340 m/min	N
wet maximum	suitable only under restricted conditions		
dry	suitable		
Air	suitable		