

Garant

Solid carbide drill plain shank unidirectional DIN 6535 HA, Diamond, Ø m7: 4,1-4,9 mm



Order data

Order number	122524 4,1-4,9
GTIN	
Item class	10N

Description

IMPORTANT: item is configurable

Version:

With the latest generation of **crystalline diamond coating sp³**, for process reliability in machining **fibre-reinforced composites, CRP, GRP, and graphite. With 90° point angle** and special geometry to **avoid delamination.**

With cutting guide chamfer to avoid delamination, projecting fibres, and burr formation on materials with **uni-directional** fibre orientation.

Recommendation:

Maximum drilling depth:

Flute length (see table) less 1.5×nominal Ø.

Note:

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

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

Tolerance nominal Ø: m7

Number of cutting edges Z: 2

Ø range (1/100 size): 4.01 - 4.99 mm

Overall length L: 74 mm

Shank Ø D_s: 6 mm

Feed f in GRP CRP: 0.06 mm/rev.

Technical description

Nominal Ø D _c	4.01 - 4.99 mm
Feed f in GRP CRP	0.06 mm/rev.
Flute length L _c	36 mm

Shank tolerance	h6
Ø range (1/100 size)	4.01 - 4.99 mm
Number of cutting edges Z	2
Tolerance nominal Ø	m7
Shank Ø D _s	6 mm
Overall length L	74 mm
Coating	Diamond
Tool material	Solid carbide
Standard	Manufacturer's standard
Drill depth up to	5×D
Point angle	90 °
Shank	DIN 6535 HA to h6
Through-coolant	no
Colour ring	black
Type of product	Jobber drill

User data

	Suitability	V _c	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		