

## Garant

### Solid carbide HPC drill plain shank DIN 6535 HA H7, TiAlN, Ø DC: 10,01mm



#### Order data

|              |               |
|--------------|---------------|
| Order number | 122790 10,01  |
| GTIN         | 4045197059222 |
| Item class   | 11E           |

#### Description

##### Version:

**Drilling and reaming in a single operation.** Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry**. Particularly high alignment accuracy due to **4 guide chamfers**.

##### Advantage:

Very tight **manufacturing tolerances** with **H7 fit** can be produced without additional reaming.

##### Note:

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

Form **HB**: order with **No. 122790 + 129100HB** .

Form **HE**: order with **No. 122790 + 129100HE**.

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

Solid carbide precision fit drills for machining aluminium available on request.

#### Technical description

|   |              |
|---|--------------|
| Feed f in steel < 900 N/mm <sup>2</sup> | 0.28 mm/rev. |
| Number of cutting edges Z               | 2            |
| Flute length L <sub>c</sub>             | 61 mm        |
| Shank tolerance                         | h6           |
| Nominal Ø D <sub>c</sub>                | 10.01 mm     |
| Shank Ø D <sub>s</sub>                  | 10 mm        |
| Overall length L                        | 103 mm       |
| Standard                                | DIN 6537     |

|  |                   |
|--|-------------------|
| recommended maximum drilling depth $L_2$ | 46 mm             |
| Tolerance                                | H7                |
| 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               |
| Colour ring                              | green             |
| Type of product                          | Jobber drill      |

## User data

|                                | Suitability                               | $V_c$     | ISO code |
|--------------------------------|---|-----------|----------|
| Steel < 500 N/mm <sup>2</sup>  | suitable                                  | 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 only under restricted conditions | 60 m/min  | P        |
| INOX < 900 N/mm <sup>2</sup>   | suitable only under restricted conditions | 35 m/min  | M        |
| INOX > 900 N/mm <sup>2</sup>   | suitable only under restricted conditions | 30 m/min  | M        |
| Uni                            | suitable                                  |           |          |
| wet maximum                    | suitable                                  |           |          |
| Air                            | suitable only under restricted conditions |           |          |

## Services

|                        |           |
|------------------------|-----------|
| Shank grinding Type HE | 129100 HE |
| Shank grinding Type HB | 129100 HB |

