

Garant
Solid carbide HPC drill plain shank DIN 6535 HA H7, TiAlN, Ø DC: 3,98mm

Order data

Order number	122790 3,98
GTIN	4045197058997
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

Shank tolerance	h6
Flute length L_c	36 mm
Nominal $\varnothing D_c$	3.98 mm
Feed f in steel $< 900 \text{ N/mm}^2$	0.12 mm/rev.
Number of cutting edges Z	2
Shank $\varnothing D_s$	6 mm
Overall length L	74 mm
Standard	DIN 6537

recommended maximum drilling depth L_2	30.1 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 ²	suitable	120 m/min	P
Steel < 750 N/mm ²	suitable	100 m/min	P
Steel < 900 N/mm ²	suitable	85 m/min	P
Steel < 1100 N/mm ²	suitable only under restricted conditions	60 m/min	P
INOX < 900 N/mm ²	suitable only under restricted conditions	35 m/min	M
INOX > 900 N/mm ²	suitable only under restricted conditions	30 m/min	M
Uni	suitable		
wet maximum	suitable		
Air	suitable only under restricted conditions		

Services

Shank grinding Type HB	129100 HB
Shank grinding Type HE	129100 HE

