

**Garant**
**Solid carbide HPC drill plain shank DIN 6535 HA H7, TiAlN, Ø DC: 3,99mm**

**Order data**

Order number	122790 3,99
GTIN	4045197059000
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
Nominal Ø D <sub>c</sub>	3.99 mm
Feed f in steel < 900 N/mm <sup>2</sup>	0.12 mm/rev.
Number of cutting edges Z	2
Flute length L <sub>c</sub>	36 mm
Shank Ø D <sub>s</sub>	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 <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

