

Garant

Solid carbide drill plain shank for uni-directional fibre orientation DIN 6535 HA, Diamond, Ø DC m7: 2,7mm



Order data

| | |
|--------------|---------------|
| Order number | 122522 2,7 |
| GTIN | 4062406349097 |
| Item class | 11Y |

Description

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.

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

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|--|----------------|
| recommended maximum drilling depth L_2 | 20 mm |
| Shank Ø D_s | 6 mm |
| Overall length L | 66 mm |
| Feed f in GRP CRP | 0.04 mm/rev. |
| Flute length L_c | 24 mm |
| Ø range (1/100 size) can be configured | 2.51 - 2.99 mm |
| Nominal Ø D_c | 2.7 mm |

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|---------------------------------|-------------------------|
| Shank tolerance | h6 |
| Number of cutting edges Z | 2 |
| Tolerance nominal \varnothing | m7 |
| Coating | Diamond |
| Tool material | Solid carbide |
| Standard | Manufacturer's standard |
| Version | 5xD |
| 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_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 | | |