

Garant
Solid carbide HPC drill plain shank DIN 6535 HA, DLC, Ø DC p6: 4,2mm

Order data

Order number	122606 4,2
GTIN	4045197568076
Item class	11E

Description
Version:

Spiral fluted, with **6 guide chamfers** and internal cooling channels.

New generation of high performance pilot drills in the HPC range.

With **140° point angle** and special **p6 cutting edge tolerance** for optimum generation of a pilot hole. High alignment accuracy and **roundness of the pilot hole**.

Note:

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

For deep-hole drilling deeper than $16 \times D$ a pilot hole is recommended, and for deep-hole drilling from $20 \times D$ to $30 \times D$ it is essential. **The generation of a pilot hole improves process reliability.**

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

Form **HB**: order with **No. 122608**.

Form **HE**: order with **No. 122606 + 129100HE**.

Technical description

Flute length L_c	36 mm
Feed f in aluminium short-chipping	0.28 mm/rev.
Number of cutting edges Z	2
Nominal $\varnothing D_c$	4.2 mm
Shank tolerance	h6
Tolerance nominal \varnothing	p6
Shank $\varnothing D_s$	6 mm
Overall length L	74 mm

Standard	DIN 6537
recommended maximum drilling depth L ₂	29.7 mm
Coating	DLC
Tool material	Solid carbide
Version	6×D
Type	W
Point angle	140 degrees
Shank	DIN 6535 HA to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Semi-Standard	yes
Colour ring	yellow
Type of product	Jobber drill

User data

	Suitability	V _c	ISO code
Alu plastics	suitable	360 m/min	N
Aluminium (short chipping)	suitable	400 m/min	N
Alu > 10% Si	suitable	350 m/min	N
PMMA acrylic	suitable	150 m/min	N
PEEK	suitable	120 m/min	N
PVDF GF20	suitable	90 m/min	N
PA 66 GF30	suitable	80 m/min	N
PEEK GF30	suitable	70 m/min	N
PTFE CF25	suitable	80 m/min	N
Cu	suitable	160 m/min	N
CuZn	suitable	200 m/min	N
GRP	suitable	80 m/min	N

CRP	suitable	80 m/min	N
wet maximum	suitable		
wet minimum	suitable		

Services

Shank grinding Type HE	129100 HE
------------------------	-----------