

Garant
Solid carbide HPC drill plain shank DIN 6535 HA, DLC, Ø DC p6: 3mm

Order data

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|--------------|---------------|
| Order number | 122606 3 |
| GTIN | 4045197567994 |
| 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 16xD a pilot hole is recommended, and for deep-hole drilling from 20xD to 30xD 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

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|------------------------------------|--------------|
| Number of cutting edges Z | 2 |
| Flute length L_c | 28 mm |
| Nominal Ø D_c | 3 mm |
| Shank tolerance | h6 |
| Feed f in aluminium short-chipping | 0.18 mm/rev. |
| Tolerance nominal Ø | p6 |
| Shank Ø D_s | 6 mm |
| Overall length L | 66 mm |

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|---|-------------------|
| Standard | DIN 6537 |
| recommended maximum drilling depth L ₂ | 23.5 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 |

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

Services

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