# Garant

## Solid carbide HPC drill plain shank DIN 6535 HA, DLC, Ø DC p6: 3,2mm



#### Order data

| Order number | 122606 3,2    |
|--------------|---------------|
| GTIN         | 4045197568007 |
| 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×D a pilot hole is recommended, and for deep-hole drilling from 20×D to 30×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**

| Feed f in aluminium short-chipping | 0.28 mm/rev. |  |
|------------------------------------|--------------|--|
| Nominal Ø D <sub>c</sub>           | 3.2 mm       |  |
| Flute length L <sub>c</sub>        | 28 mm        |  |
| Shank tolerance                    | h6           |  |
| Number of cutting edges Z          | 2            |  |
| Tolerance nominal Ø                | рб           |  |
| Shank Ø D <sub>s</sub>             | 6 mm         |  |
| Overall length L                   | 66 mm        |  |

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# Data sheet

| Standard                                 | DIN 6537          |  |  |
|--|-------------------|--|--|
| recommended maximum drilling depth $L_2$ | 23.2 mm           |  |  |
| Coating                                  | DLC               |  |  |
| Tool material                            | Solid carbide     |  |  |
| Version                                  | 6×D               |  |  |
| Туре                                     | 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 <sub>c</sub> | ISO code |
|-------------------------------|-------------|----------------|----------|
| Alu plastics                  | suitable    | 360 m/min      | Ν        |
| Aluminium (short<br>chipping) | suitable    | 400 m/min      | Ν        |
| Alu > 10% Si                  | suitable    | 350 m/min      | Ν        |
| PMMA acrylic                  | suitable    | 150 m/min      | Ν        |
| PEEK                          | suitable    | 120 m/min      | Ν        |
| PVDF GF20                     | suitable    | 90 m/min       | Ν        |
| PA 66 GF30                    | suitable    | 80 m/min       | Ν        |
| PEEK GF30                     | suitable    | 70 m/min       | Ν        |
| PTFE CF25                     | suitable    | 80 m/min       | Ν        |
| Cu                            | suitable    | 160 m/min      | Ν        |
| CuZn                          | suitable    | 200 m/min      | Ν        |
| GRP                           | suitable    | 80 m/min       | Ν        |

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| CRP                    | suitable | 80 m/min | Ν  |
|------------------------|----------|----------|----|
| wet maximum            | suitable |          |    |
| wet minimum            | suitable |          |    |
| Services               |          |          |    |
| Shank grinding Type HE |          | 129100   | HE |