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 _c	3.2 mm	
Flute length L _c	28 mm	
Shank tolerance	h6	
Number of cutting edges Z	2	
Tolerance nominal Ø	рб	
Shank Ø D _s	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 _c	ISO code
Alu plastics	suitable	360 m/min	Ν
Aluminium (short 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