

**Garant**
**Solid carbide HPC drill plain shank DIN 6535 HA, DLC, Ø DC p6: 8,5mm**

**Order data**

Order number	122606 8,5
GTIN	4045197568236
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**

Nominal $\varnothing D_c$	8.5 mm
Flute length $L_c$	61 mm
Number of cutting edges Z	2
Shank tolerance	h6
Feed f in aluminium short-chipping	0.44 mm/rev.
Tolerance nominal $\varnothing$	p6
Shank $\varnothing D_s$	10 mm
Overall length L	103 mm

Standard	DIN 6537
recommended maximum drilling depth L <sub>2</sub>	48.3 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 <sub>c</sub>	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
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