

Garant

**Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC m6 (Ø DC X = h7)
(mm or inch): 18,9**



Order data

Order number	122659 18,9
GTIN	4062406401139
Item class	11E

Description

Version:

Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry**. High roundness and alignment accuracy of the deep hole, thanks to **4 guide chamfers**. Outstanding chip evacuation due to **4 internal cooling channels** from Ø 3.8 mm. Up to 3.7 mm Ø with 2 internal cooling channels. **Straight major cutting edges** with honed edges and special flute profile for **short chips**, even on long chipping materials.

Attention:

Sizes **ending with X** = cutter Ø tolerance **h7**.

Note:

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

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

Form **HB**: order with **No. 122661**.

Form **HE**: order with **No. 122659 + 129100HE**.

Standard: DIN 6537

Tolerance nominal Ø: m6

Number of cutting edges Z: 2

recommended maximum drilling depth L_2 : 72.7 mm

Tolerance nominal Ø: m6

Overall length L: 153 mm

Shank Ø D_s : 20 mm

Feed f in stainless steel > 900 N/mm²: 0.25 mm/rev.

Technical description

Nominal Ø D_c	18.9 mm
Number of cutting edges Z	2

Shank $\varnothing D_s$	20 mm
recommended maximum drilling depth L_2	72.7 mm
Tolerance nominal \varnothing	m6
Flute length L_c	101 mm
Shank tolerance	h6
Standard	DIN 6537
Feed f in stainless steel $> 900 \text{ N/mm}^2$	0.25 mm/rev.
Overall length L	153 mm
Coating	TiAlN
Tool material	Solid carbide
Version	6xD
Point angle	140°
Shank	DIN 6535 HA to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Semi-Standard	yes
Colour ring	blue
Type of product	Jobber drill

User data

	Suitability	V_c	ISO code
Steel $< 500 \text{ N/mm}^2$	suitable	170 m/min	P
Steel $< 750 \text{ N/mm}^2$	suitable	140 m/min	P
Steel $< 900 \text{ N/mm}^2$	suitable	130 m/min	P
Steel $< 1100 \text{ N/mm}^2$	suitable	110 m/min	P
Steel $< 1400 \text{ N/mm}^2$	suitable	70 m/min	P
INOX $< 900 \text{ N/mm}^2$	suitable	90 m/min	M
INOX $> 900 \text{ N/mm}^2$	suitable	80 m/min	M
GG(G)	suitable	95 m/min	K

wet maximum	suitable
wet minimum	suitable
Air	suitable
Services	
Shank grinding Type HE	129100 HE