

**Garant**
**Solid carbide HPC drill, plain shank DIN 6535 HA, TiAlSiN, Ø DC m7: 6,8mm**

**Order data**

Order number	122480 6,8
GTIN	4062406778910
Item class	11E

**Description**
**Version:**

Specially for machining **titanium-based and nickel-based alloys**. With wear-resistant, ultra-smooth TiAlSiN high-performance coating for a **long tool life** combined with **optimum bore quality** and **very low burr formation**.

**Note:**

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

HB and HE shanks are available at the same price as HA.

For **HB**: use order **No. 122481**.

For **HE**: use order **No. 122480** and **129100HE**.

**Technical description**

Nominal Ø D <sub>c</sub>	6.8 mm
Tolerance nominal Ø	m7
Standard	DIN 6537 K
Number of cutting edges Z	2
Flute length L <sub>c</sub>	34 mm
recommended maximum drilling depth L <sub>2</sub>	23.8 mm
Overall length L	79 mm
Shank Ø D <sub>s</sub>	8 mm
Feed f in titanium > 850 N/mm <sup>2</sup>	0.09 mm/rev.
Coating	TiAlSiN

Tool material	Solid carbide
Version	4×D
Point angle	140 degrees
Shank	DIN 6535 HA to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Semi-Standard	yes
Colour ring	pink
Type of product	Jobber drill

### User data

	Suitability	V <sub>c</sub>	ISO code
Ti > 850 N/mm <sup>2</sup>	suitable		
Inconel	suitable		
wet maximum	suitable		

### Services

Shank grinding Type HE	129100 HE
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