

Garant**Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC h7: 3,4mm****Order data**

Order number	122690 3,4
GTIN	4045197706560
Item class	11E

Description**Version:**

3 guide chamfers for particularly high accuracy and surface quality at tight hole tolerances.

Asymmetrical tip geometry for **very high metal removal rates**. New generation of **innovative high-performance drills for cast iron** in the HPC field.

Advantage:

For HPC high performance drilling in castings. **Outstandingly suitable for bainite cast iron (ADI).**

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. 122690 + 129100HB**.

Form **HE**: order with **No. 122690 + 129100HE**.

Technical description

Flute length L_c	28 mm
Feed f in GJS ADI $> 800 \text{ N/mm}^2$	0.16 mm/rev.
Nominal $\varnothing D_c$	3.4 mm
Number of cutting edges Z	2
Shank tolerance	h6
Tolerance nominal $\varnothing$	h7
Shank $\varnothing D_s$	6 mm
Overall length L	66 mm

Standard	DIN 6537 L
recommended maximum drilling depth L ₂	22.9 mm
Coating	TiAlN
Tool material	Solid carbide
Version	6×D
Point angle	135 degrees
Shank	DIN 6535 HA to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Semi-Standard	yes
Colour ring	white
Type of product	Jobber drill

User data

	Suitability	V _c	ISO code
GG	suitable	110 m/min	K
GGG	suitable	90 m/min	K
GJS, ADI > 800N/mm ²	suitable	70 m/min	K
wet maximum	suitable		
wet minimum	suitable		

Suitable products

<https://www.hoffmann-group.com/GB/en/hom/p/122690-3,4>