Garant

Solid carbide HPC drill plain shank DIN 6535 HA, DLC, ⌀ DC p6: 1,0-Xmm

Order data

Order number	122606 1,0-X
GTIN	4062406075491
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**. Delivery time: 12 working weeks
Minimum order quantity: 3 pcs
Items made to order for a specific customer:
Cancellation only up to a maximum of 3 working days after receipt of order acknowledgement. Items cannot be returned. We reserve the right to over-deliver or under-deliver by ±10% (minimum 1 piece).

Technical description

Tolerance nominal ⌀	h7
Number of cutting edges Z	2
Flute length L_c	12 mm
Shank ⌀ D_s	4 mm
Standard	DIN 6537

Overall length L	55 mm
∅ range	1 - 1.55 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_c	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		