

**Garant**
**Solid carbide HPC drill plain shank DIN 6535 HA, DLC, Ø DC p6: 3,76-Xmm**

**Order data**

Order number	122606 3,76-X
GTIN	4062406078133
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**. 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  $\pm 10\%$  (minimum 1 piece).

**Technical description**

Standard	DIN 6537
Number of cutting edges Z	2
Flute length $L_c$	36 mm
Feed f in aluminium short-chipping	0.28 mm/rev.
Shank $\varnothing D_s$	6 mm

Overall length L	74 mm
Tolerance nominal $\varnothing$	h7
$\varnothing$ range	3.76 - 4.75 mm
Coating	DLC
Tool material	Solid carbide
Version	6xD
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		