

Garant
Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC p6: 8,06-Xmm

Order data

Order number	122736 8,06-X
GTIN	4062406079383
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. With **140° point angle** and special **j6 cutting edge tolerance** for optimum generation of a pilot hole.

Note:

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

For deep-hole drilling deeper than 12×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. 122738**.

Form **HE**: order with **No. 122736 + 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

Overall length L	103 mm
Shank Ø D _s	10 mm
Standard	DIN 6537
Tolerance nominal Ø	h7

Feed f in steel < 1100 N/mm ²	0.21 mm/rev.
Number of cutting edges Z	2
Flute length L _c	61 mm
Ø range	8.06 - 10.05 mm
Coating	TiAlN
Tool material	Solid carbide
Version	6×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	green
Type of product	Jobber drill

User data

	Suitability	V _c	ISO code
Steel < 500 N/mm ²	suitable	170 m/min	P
Steel < 750 N/mm ²	suitable	130 m/min	P
Steel < 900 N/mm ²	suitable	120 m/min	P
Steel < 1100 N/mm ²	suitable	110 m/min	P
Steel < 1400 N/mm ²	suitable	65 m/min	P
INOX < 900 N/mm ²	suitable	75 m/min	M
INOX > 900 N/mm ²	suitable	70 m/min	M
GG(G)	suitable	95 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable		
Air	suitable		

