

**Garant**

**Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC m6 (Ø DC X = h7)  
(mm or inch): 10,1**


**Order data**

|              |               |
|--------------|---------------|
| Order number | 122659 10,1   |
| GTIN         | 4045197582744 |
| 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. **Straight major cutting edges** with honed edges and special flute profile for **short chips**, even on long chipping materials.

**Attention:**

Sizes **ending with X** = cutter Ø tolerance **h7**.

**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. 122661**.

Form **HE**: order with **No. 122659 + 129100HE**.

Standard: DIN 6537

Tolerance nominal Ø: m6

Number of cutting edges Z: 2

recommended maximum drilling depth  $L_2$ : 55.9 mm

Tolerance nominal Ø: m6

Overall length L: 118 mm

Shank Ø  $D_s$ : 12 mm

Feed f in stainless steel > 900 N/mm<sup>2</sup>: 0.15 mm/rev.

**Technical description**

|                                                   |              |
|---------------------------------------------------|--------------|
| Feed f in stainless steel > 900 N/mm <sup>2</sup> | 0.15 mm/rev. |
| Number of cutting edges Z                         | 2            |

|                                          |                   |
|------------------------------------------|-------------------|
| Shank tolerance                          | h6                |
| Flute length $L_c$                       | 71 mm             |
| Nominal $\varnothing D_c$                | 10.1 mm           |
| Tolerance nominal $\varnothing$          | m6                |
| Shank $\varnothing D_s$                  | 12 mm             |
| Overall length L                         | 118 mm            |
| Standard                                 | DIN 6537          |
| recommended maximum drilling depth $L_2$ | 55.9 mm           |
| Coating                                  | TiAlN             |
| Tool material                            | Solid carbide     |
| Version                                  | 6xD               |
| Point angle                              | 140 °             |
| Shank                                    | DIN 6535 HA to h6 |
| Through-coolant                          | yes, with 25 bar  |
| Machining strategy                       | HPC               |
| Semi-Standard                            | yes               |
| Colour ring                              | blue              |
| Type of product                          | Jobber drill      |

## User data

|                                | Suitability | $V_c$     | ISO code |
|--------------------------------|-------------|-----------|----------|
| Steel < 500 N/mm <sup>2</sup>  | suitable    | 170 m/min | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable    | 140 m/min | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable    | 130 m/min | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable    | 110 m/min | P        |
| Steel < 1400 N/mm <sup>2</sup> | suitable    | 70 m/min  | P        |
| INOX < 900 N/mm <sup>2</sup>   | suitable    | 90 m/min  | M        |
| INOX > 900 N/mm <sup>2</sup>   | suitable    | 80 m/min  | M        |
| GG(G)                          | suitable    | 95 m/min  | K        |

|                        |                     |
|------------------------|---------------------|
| wet maximum            | suitable            |
| wet minimum            | suitable            |
| <del>Air</del>         | <del>suitable</del> |
| <b>Services</b>        |                     |
| Shank grinding Type HE | 129100 HE           |