

## Garant

### Solid carbide HPC drill, plain shank DIN 6535 HA, DLC, Ø DC h7: 19,5mm



#### Order data

Order number	122808 19,5
GTIN	4045197754639
Item class	11E

#### Description

##### Version:

**DLC coating  $sp^2$**  of the latest generation with **low coefficient of friction** results in **outstanding chip clearance**. For **high-performance milling** of **aluminium materials**. **High roundness** and **alignment accuracy of the deep hole**, thanks to **6 guide chamfers**.

##### 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. 122809**.

Form **HE**: order with **No. 122808 + 129100HE**.

Standard: Manufacturer's standard

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

recommended maximum drilling depth  $L_2$ : 160.8 mm

Tolerance nominal Ø: h7

Overall length L: 243 mm

Shank Ø  $D_s$ : 20 mm

Feed f in aluminium short-chipping: 0.7 mm/rev.

#### Technical description

Flute length $L_c$	190 mm
Number of cutting edges Z	2
Overall length L	243 mm
Nominal Ø $D_c$	19.5 mm
Shank tolerance	h6

Tolerance nominal $\varnothing$	h7
Shank $\varnothing D_s$	20 mm
Standard	Manufacturer's standard
Feed f in aluminium short-chipping	0.7 mm/rev.
recommended maximum drilling depth $L_2$	160.8 mm
Coating	DLC
Tool material	solid carbide
Version	8xD
Type	W
Point angle	135 °
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	325 m/min	N
Aluminium (short chipping)	suitable	360 m/min	N
Alu > 10% Si	suitable	315 m/min	N
PMMA acrylic	suitable	135 m/min	N
PEEK	suitable	110 m/min	N
PVDF GF20	suitable	80 m/min	N
PA 66 GF30	suitable	70 m/min	N
PEEK GF30	suitable	60 m/min	N
PTFE CF25	suitable	70 m/min	N

Cu	suitable	140 m/min	N
CuZn	suitable	160 m/min	N
GRP	suitable	70 m/min	N
CRP	suitable	70 m/min	N
wet maximum	suitable		
wet minimum	suitable		

**Services**

Shank grinding Type HE

129100 HE