

**Garant**
**Solid carbide drill plain shank DIN 6535 HA 180°, TiAlN, Ø DC m7: 11,1 mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 122793 11,1   |
| GTIN         | 4062406092276 |
| Item class   | 11E           |

**Description**
**Version:**

Special point geometry for generating **180° flat-bottomed holes**. Low radial forces even when spot drilling on faces with up to 15° slope. Flute geometry for optimum chip evacuation. With 4 guide chamfers to stabilise the drill in the hole.

**Advantage:**

**The 180° point angle** permits drilling and counterboring in a single operation.

**Recommendation:**

When using the solid carbide 180° drill it is absolutely essential for process reliability:

- **when spot drilling on flat surfaces to drill a pilot hole 1×D using pilot drill No. 122736.**
- **when spot drilling on sloping surfaces up to max. 15° : reduce the feed rate  $f$  to 25% of the stated value. After spot drilling, the normal feed rate value can be used.**

**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. 122793 + 129100HB**.

Form **HE**: order with **No. 122793 + 129100HE**.

180° solid carbide drills for machining aluminium available on request.

**Not** suitable for generating counterbores for socket-head screws to DIN974-1.

Standard: Manufacturer's standard

Tolerance nominal Ø: m7

Number of cutting edges Z: 2

Tolerance nominal Ø: m7

recommended maximum drilling depth  $L_2$ : 52.4 mm

Overall length L: 116 mm

Shank Ø  $D_s$ : 12 mm

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

**Technical description**

| Standard                                          | Manufacturer's standard       |
|---------------------------------------------------|-------------------------------|
| Number of cutting edges Z                         | 2                             |
| recommended maximum drilling depth L <sub>2</sub> | 52.4 mm                       |
| Nominal Ø D <sub>c</sub>                          | 11.1 mm                       |
| Shank tolerance                                   | h6                            |
| Flute length L <sub>c</sub>                       | 69 mm                         |
| Shank Ø D <sub>s</sub>                            | 12 mm                         |
| Feed f in steel < 900 N/mm <sup>2</sup>           | 0.15 mm/rev.                  |
| Tolerance nominal Ø                               | m7                            |
| Overall length L                                  | 116 mm                        |
| Coating                                           | TiAlN                         |
| Tool material                                     | Solid carbide                 |
| Drill depth up to                                 | 5×D                           |
| Point angle                                       | 180 degrees                   |
| Shank                                             | DIN 6535 HA to h6             |
| Use for drilling                                  | limited convexity             |
| Use for drilling                                  | limited cross-drilling        |
| Use for drilling                                  | limited oblique spot drilling |
| Through-coolant                                   | yes, with 25 bar              |
| Pilot drill required                              | yes, pilot drill              |
| Semi-Standard                                     | yes                           |
| Colour ring                                       | green                         |
| Type of product                                   | Jobber drill                  |

## Services

|                        |           |
|------------------------|-----------|
| Shank grinding Type HE | 129100 HE |
| Shank grinding Type HB | 129100 HB |

