# Garant

Solid carbide HPC drill, plain shank DIN 6535 HA, DLC, Ø DC h7: 11 mm

## Order data

Order number	123178 11
GTIN	4045197755605
Item class	11E

## Description

#### Version:

**DLC coating sp**<sup>2</sup> 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. **Recommendation:** Maximum drilling depth: flute length (see table) less 1.5×nominal Ø. Note: Flute length  $L_c = L_2 + 1.5 \times D_c$ . For process reliability when using the 12×D drill, an initial centre drilling with NC spotting drills No. 121068-121130 is necessary. Form HB and HE are supplied at the same price as HA. Order form HB: with No. 123179. Order form **HE:** with **No. 123178 + 129100HE**. Standard: Manufacturer's standard Tolerance nominal Ø: h7 Number of cutting edges Z: 2 Tolerance nominal Ø: h7 recommended maximum drilling depth L<sub>2</sub>: 139.5 mm Overall length L: 204 mm Shank Ø D<sub>s</sub>: 12 mm Feed f in aluminium short-chipping: 0.55 mm/rev.

## **Technical description**

Tolerance nominal Ø	h7
Flute length $L_c$	156 mm

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Shank Ø DsNominal Ø DcShank toleranceNumber of cutting edges ZOverall length LFeed f in aluminium short-chippingrecommended maximum drilling depth L2CoatingTool materialDrill depth up to	12 mm 11 mm h6 2 204 mm 0.55 mm/rev. 139.5 mm
Shank toleranceImage: Shank toleranceNumber of cutting edges ZImage: Shank toleranceOverall length LImage: Shank toleranceFeed f in aluminium short-chippingImage: Shank tolerancerecommended maximum drilling depth L2Image: Shank toleranceCoatingImage: Shank toleranceTool materialImage: Shank toleranceDrill depth up toImage: Shank tolerance	h6 2 204 mm 0.55 mm/rev.
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Feed f in aluminium short-chippingrecommended maximum drilling depth L2CoatingTool materialDrill depth up to	0.55 mm/rev.
recommended maximum drilling depth L <sub>2</sub> Coating Tool material Drill depth up to	
Coating Tool material Drill depth up to	139.5 mm
Tool material Drill depth up to	
Drill depth up to	DLC
	solid carbide
Turpa	12×D
Туре	W
Point angle	135 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

Shank grinding Type HE	129100 HE
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