

Garant

Solid carbide HPC drill, plain shank DIN 6535 HA, DLC, Ø DC h7: 13,8 mm



Order data

Order number	123178 13,8
GTIN	4045197755681
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**.

Recommendation:

Maximum drilling depth:

flute length (see table) less $1.5 \times \text{nominal } \varnothing$.

Note:

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

For process reliability when using the $12 \times D$ 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 \varnothing : h7

Number of cutting edges Z: 2

Semi-Standard: yes

Tolerance nominal \varnothing : h7

recommended maximum drilling depth L_2 : 161.3 mm

Overall length L: 230 mm

Shank $\varnothing D_s$: 14 mm

Feed f in aluminium short-chipping: 0.65 mm/rev.

Technical description

Feed f in aluminium short-chipping	0.65 mm/rev.
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Overall length L	230 mm
Tolerance nominal \varnothing	h7
Shank tolerance	h6
Nominal $\varnothing D_c$	13.8 mm
Shank $\varnothing D_s$	14 mm
Flute length L_c	182 mm
Number of cutting edges Z	2
Standard	Manufacturer's standard
recommended maximum drilling depth L_2	161.3 mm
Semi-Standard	yes
Coating	DLC
Tool material	solid carbide
Drill depth up to	12xD
Type	W
Point angle	135 degrees
Shank	DIN 6535 HA to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Colour ring	yellow
Type of product	Jobber drill

Services

Shank grinding Type HE	129100 HE
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