

**Garant**
**Solid carbide HPC drill, plain shank DIN 6535 HA, DLC, Ø DC h7: 17,5 mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 123178 17,5   |
| GTIN         | 4045197755797 |
| 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

Tolerance nominal  $\varnothing$ : h7

recommended maximum drilling depth  $L_2$ : 207.8 mm

Overall length L: 285 mm

Shank  $\varnothing D_s$ : 18 mm

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

**Technical description**

|                    |        |
|--------------------|--------|
| Flute length $L_c$ | 234 mm |
| Overall length L   | 285 mm |

|                                          |                         |
|------------------------------------------|-------------------------|
| Number of cutting edges Z                | 2                       |
| Feed f in aluminium short-chipping       | 0.7 mm/rev.             |
| Nominal $\varnothing D_c$                | 17.5 mm                 |
| Tolerance nominal $\varnothing$          | h7                      |
| Shank $\varnothing D_s$                  | 18 mm                   |
| Shank tolerance                          | h6                      |
| Standard                                 | Manufacturer's standard |
| recommended maximum drilling depth $L_2$ | 207.8 mm                |
| 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                     |
| Semi-Standard                            | yes                     |
| Colour ring                              | yellow                  |
| Type of product                          | Jobber drill            |

## Services

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