

## Garant

### Solid carbide HPC drill, plain shank DIN 6535 HA, DLC, Ø DC h7: 2,1 mm



#### Order data

|              |               |
|--------------|---------------|
| Order number | 123178 2,1    |
| GTIN         | 4045197754776 |
| 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  $L_2$ : 30.9 mm

Overall length L: 72 mm

Shank  $\varnothing D_s$ : 4 mm

Feed f in aluminium short-chipping: 0.22 mm/rev.

#### Technical description

|                 |                         |
|-----------------|-------------------------|
| Standard        | Manufacturer's standard |
| Shank tolerance | h6                      |

|  |                   |
|--|-------------------|
| Shank $\varnothing D_s$                  | 4 mm              |
| Flute length $L_c$                       | 34 mm             |
| Number of cutting edges Z                | 2                 |
| Nominal $\varnothing D_c$                | 2.1 mm            |
| Tolerance nominal $\varnothing$          | h7                |
| Feed f in aluminium short-chipping       | 0.22 mm/rev.      |
| Overall length L                         | 72 mm             |
| recommended maximum drilling depth $L_2$ | 30.9 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      |