

**Garant**
**Solid carbide HPC drill, plain shank DIN 6535 HA, DLC, Ø DC h7: 3,4 mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 123178 3,4    |
| GTIN         | 4045197754905 |
| 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  $L_2$ : 48.9 mm

Overall length L: 92 mm

Shank  $\varnothing D_s$ : 6 mm

Feed f in aluminium short-chipping: 0.35 mm/rev.

**Technical description**

|                    |                         |
|--------------------|-------------------------|
| Standard           | Manufacturer's standard |
| Flute length $L_c$ | 54 mm                   |

|                                                   |                   |
|---------------------------------------------------|-------------------|
| Shank Ø D <sub>s</sub>                            | 6 mm              |
| Tolerance nominal Ø                               | h7                |
| Nominal Ø D <sub>c</sub>                          | 3.4 mm            |
| Number of cutting edges Z                         | 2                 |
| Feed f in aluminium short-chipping                | 0.35 mm/rev.      |
| Shank tolerance                                   | h6                |
| Overall length L                                  | 92 mm             |
| recommended maximum drilling depth L <sub>2</sub> | 48.9 mm           |
| Coating                                           | DLC               |
| Tool material                                     | solid carbide     |
| Drill depth up to                                 | 12×D              |
| 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 |
|------------------------|-----------|