

## Garant

### Solid carbide HPC drill, plain shank DIN 6535 HA, DLC, Ø DC h7: 6,6 mm



#### Order data

|              |               |
|--------------|---------------|
| Order number | 123178 6,6    |
| GTIN         | 4045197755223 |
| 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  $L_2$ : 98.1 mm

Overall length L: 146 mm

Shank  $\varnothing D_s$ : 8 mm

Feed f in aluminium short-chipping: 0.45 mm/rev.

#### Technical description

|                           |      |
|---------------------------|------|
| Number of cutting edges Z | 2    |
| Shank $\varnothing D_s$   | 8 mm |

|  |                         |
|--|-------------------------|
| Nominal $\varnothing D_c$                | 6.6 mm                  |
| Feed f in aluminium short-chipping       | 0.45 mm/rev.            |
| Standard                                 | Manufacturer's standard |
| Flute length $L_c$                       | 108 mm                  |
| Tolerance nominal $\varnothing$          | h7                      |
| Shank tolerance                          | h6                      |
| Overall length L                         | 146 mm                  |
| recommended maximum drilling depth $L_2$ | 98.1 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 |
|------------------------|-----------|