

Garant
Solid carbide HPC drill, plain shank DIN 6535 HA, DLC, Ø DC h7: 6,9 mm

Order data

Order number	123178 6,9
GTIN	4045197755254
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 : 97.7 mm

Overall length L: 146 mm

Shank $\varnothing D_s$: 8 mm

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

Technical description

Flute length L_c	108 mm
Standard	Manufacturer's standard

Number of cutting edges Z	2
Nominal $\varnothing D_c$	6.9 mm
Tolerance nominal $\varnothing$	h7
Shank tolerance	h6
Overall length L	146 mm
Shank $\varnothing D_s$	8 mm
Feed f in aluminium short-chipping	0.45 mm/rev.
recommended maximum drilling depth L ₂	97.7 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
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