

**Garant**
**Solid carbide HPC drill, plain shank DIN 6535 HA, DLC, Ø DC h7: 8,5 mm**

**Order data**

Order number	123178 8,5
GTIN	4045197755414
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  $L_2$ : 107.3 mm

Overall length L: 162 mm

Shank  $\varnothing D_s$ : 10 mm

Feed f in aluminium short-chipping: 0.55 mm/rev.

**Technical description**

Overall length L	162 mm
Flute length $L_c$	120 mm

Shank tolerance	h6
Feed f in aluminium short-chipping	0.55 mm/rev.
Number of cutting edges Z	2
Shank $\varnothing D_s$	10 mm
Standard	Manufacturer's standard
Nominal $\varnothing D_c$	8.5 mm
Tolerance nominal $\varnothing$	h7
recommended maximum drilling depth $L_2$	107.3 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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