Garant

Solid carbide HPC drill, plain shank DIN 6535 HA, DLC, ⌀ DC h7: 9,7 mm

Order data

Order number	123178 9,7
GTIN	4045197755537
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×nominal ⌀.
Note:
Flute length $L_C = L_2 + 1.5 \times D_C$.
For process reliability when using the 12×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 ⌀: h7
Number of cutting edges Z: 2
Tolerance nominal ⌀: h7
recommended maximum drilling depth L_2: 105.5 mm
Overall length L: 162 mm
Shank ⌀ D_s: 10 mm
Feed f in aluminium short-chipping: 0.55 mm/rev.

Technical description

Nominal ⌀ D_C	9.7 mm
Overall length L	162 mm

Shank tolerance	h6
Shank ⌀ D_s	10 mm
Standard	Manufacturer's standard
Feed f in aluminium short-chipping	0.55 mm/rev.
Number of cutting edges Z	2
Flute length L_c	120 mm
Tolerance nominal ⌀	h7
recommended maximum drilling depth L_2	105.5 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