

## Garant

### Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC m6 (mm or inch): 18 mm or inch



#### Order data

Order number	123008 18
GTIN	4045197570048
Item class	11E

#### Description

##### Version:

Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry**. High roundness and alignment accuracy of the deep hole, thanks to **4 guide chamfers**. Outstanding chip evacuation due to **4 internal cooling channels** from Ø 3.8 mm. Up to 3.7 mm Ø with 2 internal cooling channels. **Straight major cutting edges** with honed edges and special flute profile for **short chips**, even on long chipping materials.

##### Recommendation:

##### Maximum drilling depth:

Flute length (see table) less 1.5×nominal Ø.

##### Note:

Form HB and HE supplied at the same price as HA.

Form **HB**: order with **No. 123010**.

Form **HE**: order with **No. 123008 + 129100HE**.

Flute length  $L_c = L_2 + 1.5 \times D_c$ .

Standard: Manufacturer's standard

Tolerance nominal Ø: m6

Number of cutting edges Z: 2

Tolerance nominal Ø: m6

recommended maximum drilling depth  $L_2$ : 144 mm

Overall length L: 222 mm

Shank Ø  $D_s$ : 18 mm

Feed f in stainless steel > 900 N/mm<sup>2</sup>: 0.25 mm/rev.

#### Technical description

Number of cutting edges Z	2
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Flute length $L_c$	171 mm
Shank tolerance	h6
Nominal $\varnothing D_c$	18 mm
Feed $f$ in stainless steel $> 900 \text{ N/mm}^2$	0.25 mm/rev.
Tolerance nominal $\varnothing$	m6
Shank $\varnothing D_s$	18 mm
Overall length $L$	222 mm
Standard	Manufacturer's standard
recommended maximum drilling depth $L_2$	144 mm
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	8xD
Point angle	140 degrees
Shank	DIN 6535 HA to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Semi-Standard	yes
Colour ring	blue
Type of product	Jobber drill

## Services

Shank grinding Type HE	129100 HE
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