

## Garant

**Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC h7: 19,5 mm**



### Order data

|              |               |
|--------------|---------------|
| Order number | 123110 19,5   |
| GTIN         | 4045197357977 |
| Item class   | 11E           |

### Description

#### Version:

Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry**.

Particularly high alignment accuracy due to **4 guide chamfers** which stabilise the drill even at extreme depths!

**Straight major cutting edges** with honed edges and special flute profile for **short chips**, even on long chipping materials.

#### Advantage:

**High process reliability and surface quality of the hole.**

#### Recommendation:

##### Maximum drilling depth:

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

##### Note:

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

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

Form **HB**: order with **No. 123115**.

Form **HE**: order with **No. 123110 + 129100 HE**.

Standard: Manufacturer's standard

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

Tolerance nominal Ø: h7

recommended maximum drilling depth  $L_2$ : 204.8 mm

Overall length L: 286 mm

Shank Ø  $D_s$ : 20 mm

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

### Technical description

|   |                         |
|---|-------------------------|
| Flute length $L_c$                                | 234 mm                  |
| Number of cutting edges Z                         | 2                       |
| Nominal $\varnothing D_c$                         | 19.5 mm                 |
| Shank tolerance                                   | h6                      |
| Feed f in stainless steel < 900 N/mm <sup>2</sup> | 0.25 mm/rev.            |
| Tolerance nominal $\varnothing$                   | h7                      |
| Shank $\varnothing D_s$                           | 20 mm                   |
| Overall length L                                  | 286 mm                  |
| Standard  | Manufacturer's standard |
| recommended maximum drilling depth $L_2$          | 204.8 mm                |
| Coating   | TiAlN                   |
| Tool material                                     | Solid carbide           |
| Drill depth up to                                 | 10xD                    |
| Point angle                                       | 135 degrees             |
| Cutting direction                                 | right-hand              |
| 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 |
|------------------------|-----------|