

Garant

Solid carbide HPC drill Weldon shank DIN 6535 HB, DLC, Ø DC h7: 13,8 mm



Order data

Order number	123179 13,8
GTIN	4045197760401
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:

clamping slot 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 $12 \times D$ deep-hole drill, an initial centre drilling with No. 121068 – 121130 is necessary.

Standard: Manufacturer's standard

Tolerance nominal \varnothing : h7

Number of cutting edges Z: 2

Tolerance nominal \varnothing : h7

recommended maximum drilling depth L_2 : 161.3 mm

Overall length L: 230 mm

Shank $\varnothing D_s$: 14 mm

Feed f in aluminium short-chipping: 0.65 mm/rev.

Technical description

Number of cutting edges Z	2
Shank $\varnothing D_s$	14 mm
Feed f in aluminium short-chipping	0.65 mm/rev.
Nominal $\varnothing D_c$	13.8 mm

Tolerance nominal \varnothing	h7
Flute length L_c	182 mm
Shank tolerance	h6
Standard	Manufacturer's standard
Overall length L	230 mm
recommended maximum drilling depth L_2	161.3 mm
Coating	DLC
Tool material	solid carbide
Drill depth up to	12xD
Type	W
Point angle	135 degrees
Cutting direction	right-hand
Shank	DIN 6535 HB to h6
Through-coolant	Yes, with 25 bar
Machining strategy	HPC
Semi-Standard	yes
Colour ring	yellow
Type of product	Jobber drill