

## Garant

### Solid carbide HPC drill Weldon shank DIN 6535 HB, DLC, Ø DC h7: 7,7 mm



#### Order data

Order number	123179 7,7
GTIN	4045197760050
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  $L_2$ : 96.5 mm

Overall length L: 146 mm

Shank  $\varnothing D_s$ : 8 mm

Feed f in aluminium short-chipping: 0.45 mm/rev.

#### Technical description

Shank tolerance	h6
Tolerance nominal $\varnothing$	h7
Shank $\varnothing D_s$	8 mm
Nominal $\varnothing D_c$	7.7 mm

Overall length L	146 mm
Number of cutting edges Z	2
Flute length L <sub>c</sub>	108 mm
Feed f in aluminium short-chipping	0.45 mm/rev.
Standard	Manufacturer's standard
recommended maximum drilling depth L <sub>2</sub>	96.5 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