

## Garant

### Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC h7: 6,6 mm



#### Order data

|              |               |
|--------------|---------------|
| Order number | 123301 6,6    |
| GTIN         | 4045197452412 |
| 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!

**Convex 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  $L_c = L_2 + 1.5 \times D_c$ .

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.

Form **HB**: order with **No. 123302**.

Form **HE**: order with **No. 123301 + 129100HE**.

##### **NEW GENERATION AVAILABLE!**

**Recommended successor products are No. 123225 and 123235.**

Standard: Manufacturer's standard

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

Tolerance nominal Ø: h7

recommended maximum drilling depth  $L_2$ : 98.1 mm

Overall length L: 146 mm

Shank Ø  $D_s$ : 8 mm

Feed f in steel < 1100 N/mm<sup>2</sup>: 0.15 mm/rev.

## Technical description

|   |                         |
|---|-------------------------|
| Nominal $\varnothing D_c$                 | 6.6 mm                  |
| Flute length $L_c$                        | 108 mm                  |
| Feed $f$ in steel $< 1100 \text{ N/mm}^2$ | 0.15 mm/rev.            |
| Number of cutting edges $Z$               | 2                       |
| Shank tolerance                           | h6                      |
| Tolerance nominal $\varnothing$           | h7                      |
| Shank $\varnothing D_s$                   | 8 mm                    |
| Overall length $L$                        | 146 mm                  |
| Standard                                  | Manufacturer's standard |
| recommended maximum drilling depth $L_2$  | 98.1 mm                 |
| Coating                                   | TiAlN                   |
| Tool material                             | Solid carbide           |
| Drill depth up to                         | 12xD                    |
| Point angle                               | 135 degrees             |
| Shank                                     | DIN 6535 HA to h6       |
| Through-coolant                           | yes, with 25 bar        |
| Machining strategy                        | HPC                     |
| Semi-Standard                             | yes                     |
| Colour ring                               | green                   |
| Type of product                           | Jobber drill            |

## Services

|                        |           |
|------------------------|-----------|
| Shank grinding Type HE | 129100 HE |
|------------------------|-----------|