

Garant

Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC h7: 6,8 mm



Order data

Order number	123301 6,8
GTIN	4045197452429
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 : 97.8 mm

Overall length L: 146 mm

Shank Ø D_s : 8 mm

Feed f in steel < 1100 N/mm²: 0.15 mm/rev.

Technical description

Nominal $\varnothing D_c$	6.8 mm
Number of cutting edges Z	2
Flute length L_c	108 mm
Shank tolerance	h6
Feed f in steel < 1100 N/mm ²	0.15 mm/rev.
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	97.8 mm
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	12×D
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
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