

Garant

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



Order data

Order number	123302 13
GTIN	4045197459381
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:

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 or $3 \times D$ pilot drilling operation with No. 122736 is necessary.

NEW GENERATION AVAILABLE!

Recommended successor products are No. 123226 and 123236.

Standard: Manufacturer's standard

Tolerance nominal \varnothing : h7

Number of cutting edges Z: 2

Semi-Standard: yes

Tolerance nominal \varnothing : h7

recommended maximum drilling depth L_2 : 162.5 mm

Overall length L: 230 mm

Shank $\varnothing D_s$: 14 mm

Feed f in steel $< 1100 \text{ N/mm}^2$: 0.26 mm/rev.

Technical description

Flute length L_c	182 mm
Nominal $\varnothing D_c$	13 mm
Shank tolerance	h6
Number of cutting edges Z	2
Feed f in steel < 1100 N/mm ²	0.26 mm/rev.
Tolerance nominal \varnothing	h7
Shank $\varnothing D_s$	14 mm
Overall length L	230 mm
Standard	Manufacturer's standard
recommended maximum drilling depth L_2	162.5 mm
Semi-Standard	yes
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	12xD
Point angle	135 degrees
Shank	DIN 6535 HB to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Pilot drill required	yes, pilot drill
Colour ring	green
Type of product	Jobber drill