

**Garant**
**Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 5 mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 123302 5      |
| GTIN         | 4045197459152 |
| 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×nominal Ø.

**Note:**

Flute length  $L_c = L_2 + 1.5 \times D_c$ .

For process reliability when using the 12×D deep-hole drill, an initial centre drilling with No. 121068 – 121130 or 3×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 Ø: h7

Number of cutting edges Z: 2

Semi-Standard: yes

Tolerance nominal Ø: h7

recommended maximum drilling depth  $L_2$ : 70.5 mm

Overall length L: 116 mm

Shank Ø  $D_s$ : 6 mm

Feed  $f$  in steel < 1100 N/mm<sup>2</sup>: 0.1 mm/rev.

## Technical description

|  |                         |
|--|-------------------------|
| Nominal $\varnothing D_c$                  | 5 mm                    |
| Flute length $L_c$                         | 78 mm                   |
| Feed $f$ in steel < 1100 N/mm <sup>2</sup> | 0.1 mm/rev.             |
| Number of cutting edges $Z$                | 2                       |
| Shank tolerance                            | h6                      |
| Tolerance nominal $\varnothing$            | h7                      |
| Shank $\varnothing D_s$                    | 6 mm                    |
| Overall length $L$                         | 116 mm                  |
| Standard                                   | Manufacturer's standard |
| recommended maximum drilling depth $L_2$   | 70.5 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            |