

Garant
Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 6,8 mm

Order data

Order number	123302 6,8
GTIN	4045197459220
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 : 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

Flute length L_c	108 mm
Nominal $\varnothing D_c$	6.8 mm
Shank tolerance	h6
Number of cutting edges Z	2
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
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