

Garant

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



Order data

Order number	123302 6
GTIN	4045197459183
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 12xD deep-hole drill, an initial centre drilling with No. 121068 – 121130 or 3xD 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

Tolerance nominal \varnothing : h7

recommended maximum drilling depth L_2 : 69 mm

Overall length L: 116 mm

Shank $\varnothing D_s$: 6 mm

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

Technical description

Number of cutting edges Z	2
Flute length L_c	78 mm
Nominal $\varnothing D_c$	6 mm
Shank tolerance	h6
Feed f in steel < 1100 N/mm ²	0.15 mm/rev.
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	69 mm
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	12×D
Point angle	135 degrees
Cutting direction	right-hand
Shank	DIN 6535 HB to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Pilot drill required	yes, pilot drill
Semi-Standard	yes
Colour ring	green
Type of product	Jobber drill