Garant

Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, ⌀ DC h7: 9 mm

Order data

Order number	123302 9
GTIN	4045197459299
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 ⌀.
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 ⌀: h7
Number of cutting edges Z: 2
Tolerance nominal ⌀: h7
recommended maximum drilling depth L_2: 106.5 mm
Overall length L: 162 mm
Shank ⌀ D_s: 10 mm
Feed f in steel < 1100 N/mm^2: 0.2 mm/rev.

Technical description

Number of cutting edges Z	2
Shank tolerance	h6
Flute length L_c	120 mm
Feed f in steel < 1100 N/mm^2	0.2 mm/rev.
Nominal ⌀ D_C	9 mm
Tolerance nominal ⌀	h7
Shank ⌀ D_s	10 mm
Overall length L	162 mm
Standard	Manufacturer's standard
recommended maximum drilling depth L_2	106.5 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