

## Garant

### Solid carbide HPC deep-hole drill plain shank DIN 6535 HA 16×D, DLC, Ø DC h7: 2,4 mm



## Order data

|              |               |
|--------------|---------------|
| Order number | 123588 2,4    |
| GTIN         | 4045197646767 |
| Item class   | 11E           |

## Description

### Version:

Spiral fluted, with **6 guide chamfers** and internal cooling channels. New generation of high performance deep hole drills in the HPC range. **With 135° point angle** and special **h7 cutting edge tolerance** for optimum generation of a deep hole. **High roundness and alignment accuracy of the deep hole.**

### Recommendation:

#### Maximum drilling depth:

flute 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 16×D deep hole drill, an initial centre drilling with No. 121068 – 121130 or 4×D pilot drilling operation with pilot drill No. 122606 is necessary. For deep holes greater than 20×D, a 6×D pilot hole with pilot drill No. 122606 is absolutely essential.

**The generation of a pilot hole improves process reliability.** See also pages 129/130.

Standard: Manufacturer's standard

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

Tolerance nominal Ø: h7

recommended maximum drilling depth  $L_2$ : 50.4 mm

Overall length L: 96 mm

Shank Ø  $D_s$ : 4 mm

Feed f in aluminium short-chipping: 0.14 mm/rev.

## Technical description

|                                    |              |
|------------------------------------|--------------|
| Feed f in aluminium short-chipping | 0.14 mm/rev. |
|------------------------------------|--------------|

|  |                         |
|--|-------------------------|
| Flute length $L_c$                       | 54 mm                   |
| Number of cutting edges Z                | 2                       |
| Nominal $\varnothing D_c$                | 2.4 mm                  |
| Tolerance nominal $\varnothing$          | h7                      |
| Shank $\varnothing D_s$                  | 4 mm                    |
| Overall length L                         | 96 mm                   |
| Standard                                 | Manufacturer's standard |
| recommended maximum drilling depth $L_2$ | 50.4 mm                 |
| Coating                                  | DLC                     |
| Tool material                            | Solid carbide           |
| Drill depth up to                        | 16×D                    |
| Point angle                              | 135 degrees             |
| Shank                                    | DIN 6535 HA to h6       |
| Through-coolant                          | yes, with 40 bar        |
| Machining strategy                       | HPC                     |
| Pilot drill required                     | yes, pilot drill        |
| Colour ring                              | yellow                  |
| Type of product                          | Jobber drill            |