Garant

Solid carbide HPC deep-hole drill plain shank DIN 6535 HA 20×D, DLC, ⌀ DC h7: 9 mm

Order data

Order number	123590 9
GTIN	4045197354068
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 ⌀.
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 ⌀: h7
Number of cutting edges Z: 2
Tolerance nominal ⌀: h7
recommended maximum drilling depth L_2: 216.5 mm
Overall length L: 290 mm
Shank ⌀ D_s: 10 mm
Feed f in aluminium short-chipping: 0.33 mm/rev.

Technical description

Number of cutting edges Z	2

Nominal ⌀ D_C	9 mm
Flute length L_c	230 mm
Feed f in aluminium short-chipping	0.33 mm/rev.
Tolerance nominal ⌀	h7
Shank ⌀ D_s	10 mm
Overall length L	290 mm
Standard	Manufacturer's standard
recommended maximum drilling depth L_2	216.5 mm
Coating	DLC
Tool material	Solid carbide
Drill depth up to	20×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