

Garant

Solid carbide HPC deep-hole drill plain shank DIN 6535 HA 25×D, DLC, Ø DC h7: 6,8 mm



Order data

| | |
|--------------|---------------|
| Order number | 123593 6,8 |
| GTIN | 4045197454010 |
| 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 : 189.8 mm

Overall length L: 240 mm

Shank Ø D_s : 8 mm

Feed f in aluminium short-chipping: 0.28 mm/rev.

Technical description

| | |
|---------------------------|---|
| Number of cutting edges Z | 2 |
|---------------------------|---|

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|--|-------------------------|
| Feed f in aluminium short-chipping | 0.28 mm/rev. |
| Nominal $\varnothing D_c$ | 6.8 mm |
| Flute length L_c | 200 mm |
| Tolerance nominal \varnothing | h7 |
| Shank $\varnothing D_s$ | 8 mm |
| Overall length L | 240 mm |
| Standard | Manufacturer's standard |
| recommended maximum drilling depth L_2 | 189.8 mm |
| Coating | DLC |
| Tool material | Solid carbide |
| Drill depth up to | 25×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 |