

Garant

Solid carbide HPC deep-hole drill plain shank DIN 6535 HA 30×D, DLC, Ø DC h7: 11,8 mm



Order data

Order number	123595 11,8
GTIN	4045197355157
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 : 362.3 mm

Overall length L: 430 mm

Shank Ø D_s : 12 mm

Feed f in aluminium short-chipping: 0.34 mm/rev.

Technical description

Flute length L_c	380 mm
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Nominal $\varnothing D_c$	11.8 mm
Feed f in aluminium short-chipping	0.34 mm/rev.
Number of cutting edges Z	2
Tolerance nominal \varnothing	h7
Shank $\varnothing D_s$	12 mm
Overall length L	430 mm
Standard	Manufacturer's standard
recommended maximum drilling depth L_2	362.3 mm
Coating	DLC
Tool material	Solid carbide
Drill depth up to	30×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

Services

Shank grinding Type HB	129100 HB
Shank grinding Type HE	129100 HE