⋆ꚙ Hoffmann Group

Garant

Solid carbide HPC deep-hole drill plain shank DIN 6535 HA 30×D, DLC, Ø DC h7: 3,5 mm

Order data

Order number	123595 3,5
GTIN	4045197354921
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: 129.8 mm
Overall length L: 185 mm
Shank Ø D_s: 6 mm
Feed f in aluminium short-chipping: 0.15 mm/rev.

Technical description

Number of cutting edges Z	2

Feed f in aluminium short-chipping	0.15 mm/rev.
Flute length L_c	135 mm
Nominal $\varnothing$ D_c	3.5 mm
Tolerance nominal $\varnothing$	h7
Shank $\varnothing$ D_s	6 mm
Overall length L	185 mm
Standard	Manufacturer's standard
recommended maximum drilling depth L_2	129.8 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