

## Garant

### Solid carbide HPC deep-hole drill plain shank DIN 6535 HA 20xD, TiAlN, Ø DC h7: 2,8 mm



#### Order data

|              |               |
|--------------|---------------|
| Order number | 123690 2,8    |
| GTIN         | 4045197320223 |
| Item class   | 11E           |

#### Description

##### Version:

Spiral fluted, with **4 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 16xD deep-hole drill, an initial centre drilling with No. 121068 – 121130 or 4xD pilot drilling operation with pilot drill No. 122736 is necessary. For deep holes greater than 20xD, a 6xD pilot hole with pilot drill No. 122736 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  $L_2$ : 65.8 mm

Overall length L: 112 mm

Shank Ø  $D_s$ : 4 mm

Feed f in steel < 900 N/mm<sup>2</sup>: 0.06 mm/rev.

#### Technical description

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

|                                          |                         |
|------------------------------------------|-------------------------|
| Flute length $L_c$                       | 70 mm                   |
| Feed $f$ in steel $< 900 \text{ N/mm}^2$ | 0.06 mm/rev.            |
| Nominal $\varnothing D_c$                | 2.8 mm                  |
| Tolerance nominal $\varnothing$          | h7                      |
| Shank $\varnothing D_s$                  | 4 mm                    |
| Overall length $L$                       | 112 mm                  |
| Standard                                 | Manufacturer's standard |
| recommended maximum drilling depth $L_2$ | 65.8 mm                 |
| Coating                                  | TiAlN                   |
| Tool material                            | Solid carbide           |
| Drill depth up to                        | 20xD                    |
| 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                              | green                   |
| Type of product                          | Jobber drill            |