Hoffmann Group

Garant

Solid carbide HPC deep-hole drill plain shank DIN 6535 HA 20×D, TiAlN, Ø DC h7: 3,5 mm

Order data

Order number	123690 3,5
GTIN	4045197263551
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 16×D deep-hole drill, an initial centre drilling with No. 121068 – 121130 or 4×D pilot drilling operation with pilot drill No. 122736 is necessary. For deep holes greater than 20×D, a 6×D 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: 74.8 mm
Overall length L: 120 mm
Shank Ø D_s: 6 mm
Feed f in steel < 900 N/mm^2: 0.08 mm/rev.

Technical description

Flute length L_c	80 mm

Nominal Ø D_C	3.5 mm
Feed f in steel < 900 N/mm^2	0.08 mm/rev.
Number of cutting edges Z	2
Tolerance nominal Ø	h7
Shank Ø D_s	6 mm
Overall length L	120 mm
Standard	Manufacturer's standard
recommended maximum drilling depth L_2	74.8 mm
Coating	TiAlN
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	green
Type of product	Jobber drill