

Solid carbide HPC deep-hole drill plain shank DIN 6535 HA 20×D, TiAlN, \varnothing DC h7: 6,8 mm

Order data

Order number	123690 6,8
GTIN	4045197320292
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 $1.5 \times \text{nominal } \emptyset$.

Note:

Flute length $L_c = L_2 + 1.5 \times D_c$.

For process reliability when using the $16\times D$ deep-hole drill, an initial centre drilling with No. 121068 - 121130 or $4\times D$ pilot drilling operation with pilot drill No. 122736 is necessary. For deep holes greater than $20\times D$, a $6\times D$ 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 L₂: 149.8 mm

Overall length L: 210 mm

Shank Ø D_s: 8 mm

Feed f in steel < 900 N/mm²: 0.14 mm/rev.

Technical description

Nominal Ø D _c Flute length L _c 160 mm Folerance nominal Ø 5hank Ø D _s 8 mm Overall length L 5tandard Manufacturer's standard recommended maximum drilling depth L ₂ 149.8 mm Coating TiAIN Fool material Solid carbide Orill depth up to Point angle Shank DIN 6535 HA to h6 Through-coolant Machining strategy HPC Pilot drill required Colour ring 6.8 mm 6.8 mm 6.8 mm 6.8 mm Manufacturer's standard Manufacturer's standard Manufacturer's standard 149.8 mm Coating TiAIN Tool material Solid carbide 135 degrees HPC Pilot drill required yes, pilot drill Golour ring green	Feed f in steel < 900 N/mm ²	0.14 mm/rev.
Flute length L _c 160 mm Folerance nominal Ø h7 Shank Ø D _s 8 mm Overall length L Standard Manufacturer's standard Fecommended maximum drilling depth L ₂ 149.8 mm Coating TiAIN Fool material Solid carbide Orill 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	Number of cutting edges Z	2
Folerance nominal Ø h7 Shank Ø D _s 8 mm Overall length L 210 mm Standard Manufacturer's standard recommended maximum drilling depth L ₂ 149.8 mm Coating TiAIN Fool material Solid carbide Orill 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	Nominal Ø D _c	6.8 mm
Shank Ø D₃ Overall length L Standard Manufacturer's standard recommended maximum drilling depth L₂ Coating TiAIN Tool material Solid carbide Orill depth up to Point angle Shank DIN 6535 HA to h6 Through-coolant Machining strategy HPC Pilot drill required Colour ring Samm Manufacturer's standard Manufacturer's standard Manufacturer's standard Solid carbide 149.8 mm Solid carbide 135 degrees DIN 6535 HA to h6 Through-coolant Yes, with 40 bar HPC Pilot drill required Yes, pilot drill Colour ring	Flute length L _c	160 mm
Diverall length L Standard Manufacturer's standard recommended maximum drilling depth L₂ 149.8 mm Tool material Solid carbide Drill depth up to Point angle Shank DIN 6535 HA to h6 Through-coolant Machining strategy HPC Pilot drill required Colour ring Standard Manufacturer's standard Manufacturer's standard 149.8 mm TiAIN Solid carbide 20×D 135 degrees HPC yes, with 40 bar HPC yes, pilot drill Golour ring	Tolerance nominal Ø	h7
Standard Manufacturer's standard recommended maximum drilling depth L ₂ 149.8 mm Tool material Solid carbide Drill depth up to Point angle Shank DIN 6535 HA to h6 Through-coolant Machining strategy HPC Pilot drill required Colour ring Manufacturer's standard Manufacturer's stand	Shank Ø D₅	8 mm
recommended maximum drilling depth L ₂ TiAlN Tool material Orill depth up to Point angle Shank DIN 6535 HA to h6 Through-coolant Machining strategy Pilot drill required Colour ring TiAlN 149.8 mm TiAlN Solid carbide 20×D 20×D 135 degrees DIN 6535 HA to h6 Yes, with 40 bar HPC Pilot drill required Tyes, pilot drill Golour ring Green	Overall length L	210 mm
TiAIN Tool material Drill depth up to Point angle Shank DIN 6535 HA to h6 Through-coolant Machining strategy Pilot drill required Colour ring TiAIN Solid carbide 20×D 135 degrees HDC yes, with 40 bar HPC yes, pilot drill green	Standard	Manufacturer's standard
Fool material Fool m	recommended maximum drilling depth L ₂	149.8 mm
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	Coating	TiAlN
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	Tool material	Solid carbide
DIN 6535 HA to h6 Through-coolant Wachining strategy Pilot drill required Colour ring DIN 6535 HA to h6 yes, with 40 bar HPC yes, pilot drill green	Drill depth up to	20×D
Through-coolant Wachining strategy Pilot drill required Colour ring Yes, with 40 bar HPC yes, pilot drill green	Point angle	135 degrees
Machining strategy HPC Pilot drill required Yes, pilot drill Golour ring green	Shank	DIN 6535 HA to h6
Pilot drill required yes, pilot drill Colour ring green	Through-coolant	yes, with 40 bar
Colour ring green	Machining strategy	HPC
-	Pilot drill required	yes, pilot drill
Type of product Jobber drill	Colour ring	green
	Type of product	Jobber drill