

## Garant

### Solid carbide HPC deep-hole drill plain shank DIN 6535 HA 20xD, TiAlN, Ø 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×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  $L_2$ : 149.8 mm

Overall length L: 210 mm

Shank Ø  $D_s$ : 8 mm

Feed  $f$  in steel < 900 N/mm<sup>2</sup>: 0.14 mm/rev.

#### Technical description

Feed f in steel < 900 N/mm <sup>2</sup>	0.14 mm/rev.
Number of cutting edges Z	2
Nominal Ø D <sub>c</sub>	6.8 mm
Flute length L <sub>c</sub>	160 mm
Tolerance nominal Ø	h7
Shank Ø D <sub>s</sub>	8 mm
Overall length L	210 mm
Standard	Manufacturer's standard
recommended maximum drilling depth L <sub>2</sub>	149.8 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