

Garant

Solid carbide HPC deep-hole drill plain shank DIN 6535 HA 20×D, TiAlN, Ø DC h7: 8,5 mm



Order data

| | |
|--------------|---------------|
| Order number | 123690 8,5 |
| GTIN | 4045197263650 |
| 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 : 182.3 mm

Overall length L: 260 mm

Shank Ø D_s : 10 mm

Feed f in steel < 900 N/mm²: 0.16 mm/rev.

Technical description

| | |
|--------------------|--------|
| Flute length L_c | 195 mm |
|--------------------|--------|

| | |
|---|-------------------------|
| Number of cutting edges Z | 2 |
| Nominal $\varnothing D_c$ | 8.5 mm |
| Feed f in steel < 900 N/mm ² | 0.16 mm/rev. |
| Tolerance nominal \varnothing | h7 |
| Shank $\varnothing D_s$ | 10 mm |
| Overall length L | 260 mm |
| Standard | Manufacturer's standard |
| recommended maximum drilling depth L ₂ | 182.3 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 |