

## Garant

### Solid carbide HPC co-pilot drill, plain shank DIN 6535 HA 20xD, TiAlN, Ø DC: 6,8 mm



#### Order data

Order number	123691 6,8
GTIN	4045197569202
Item class	11E

#### Description

##### Version:

Helical fluted, with **4 guide chamfers** and internal coolant holes. New generation of high performance co-pilot drills in the HPC range. **With 138° point angle** and special **j6 cutting edge tolerance** for optimum generation of a co-pilot hole. **High roundness and alignment accuracy of the co-pilot hole.**

##### Recommendation:

##### Maximum drilling depth:

Flute length (see table) less 1.5×nominal Ø.

##### Note:

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

To achieve good process reliability with 40xD and 50xD deep-hole drills it is absolutely essential to drill 6xD pilot hole with a No. 122736 and a 20xD co-pilot hole with a No. 123691 co-pilot drill.

**The generation of a pilot hole improves process reliability.** See also pages 129/130.

Standard: Manufacturer's standard

Tolerance nominal Ø: j6

Number of cutting edges Z: 2

Tolerance nominal Ø: j6

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>: 0.12 mm/rev.

#### Technical description

Flute length $L_c$	160 mm
Nominal Ø $D_c$	6.8 mm

Number of cutting edges Z	2
Feed f in steel < 900 N/mm <sup>2</sup>	0.12 mm/rev.
Tolerance nominal Ø	j6
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	138 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