

Garant

Solid carbide HPC co-pilot drill, plain shank DIN 6535 HA 20xD, TiAlN, Ø DC: 8,5 mm



Order data

Order number	123691 8,5
GTIN	4045197569257
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 : 182.3 mm

Overall length L: 260 mm

Shank Ø D_s : 10 mm

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

Technical description

Nominal Ø D_c	8.5 mm
Flute length L_c	195 mm

Number of cutting edges Z	2
Feed f in steel < 900 N/mm ²	0.14 mm/rev.
Tolerance nominal Ø	j6
Shank Ø 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	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