

## Garant

### Solid carbide HPC deep-hole drill plain shank DIN 6535 HA 25×D, TiAlN, Ø DC h7: 6,8 mm



#### Order data

Order number	123693 6,8
GTIN	4045197454157
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:

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.

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

Standard: Manufacturer's standard

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

Tolerance nominal Ø: h7

recommended maximum drilling depth  $L_2$ : 189.8 mm

Overall length L: 240 mm

Shank Ø  $D_s$ : 8 mm

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

#### Technical description

Nominal Ø $D_c$	6.8 mm
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Flute length $L_c$	200 mm
Feed $f$ in steel $< 900 \text{ N/mm}^2$	0.14 mm/rev.
Number of cutting edges $Z$	2
Tolerance nominal $\varnothing$	h7
Shank $\varnothing D_s$	8 mm
Overall length $L$	240 mm
Standard	Manufacturer's standard
recommended maximum drilling depth $L_2$	189.8 mm
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	25xD
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