

Garant

Solid carbide HPC deep-hole drill plain shank DIN 6535 HA 25×D, TiAlN, Ø DC h7: 8,5 mm



Order data

Order number	123693 8,5
GTIN	4045197320704
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 : 227.3 mm

Overall length L: 285 mm

Shank Ø D_s : 10 mm

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

Technical description

Flute length L_c	240 mm
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Nominal $\varnothing D_c$	8.5 mm
Feed f in steel < 900 N/mm ²	0.16 mm/rev.
Number of cutting edges Z	2
Tolerance nominal \varnothing	h7
Shank $\varnothing D_s$	10 mm
Overall length L	285 mm
Standard	Manufacturer's standard
recommended maximum drilling depth L ₂	227.3 mm
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	25×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