

Garant

Solid carbide HPC deep-hole drill plain shank DIN 6535 HA 40xD, TiAlN, Ø DC: 6,8 mm



Order data

Order number	123740 6,8
GTIN	4045197498199
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 **fg6 cutting edge tolerance** for optimum generation of deep holes. **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 $L_c = L_2 + 1.5 \times D_c$.

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: fg6

Number of cutting edges Z: 2

Tolerance nominal Ø: fg6

recommended maximum drilling depth L_2 : 289.8 mm

Overall length L: 345 mm

Shank Ø D_s : 8 mm

Feed f in steel < 900 N/mm²: 0.12 mm/rev.

Technical description

Flute length L_c	300 mm
Feed f in steel < 900 N/mm ²	0.12 mm/rev.

Nominal $\varnothing D_c$	6.8 mm
Number of cutting edges Z	2
Tolerance nominal \varnothing	fg6
Shank $\varnothing D_s$	8 mm
Overall length L	345 mm
Standard	Manufacturer's standard
recommended maximum drilling depth L_2	289.8 mm
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	40xD
Point angle	135 degrees
Shank	DIN 6535 HA to h6
Through-coolant	yes, with 40 bar
Machining strategy	HPC
Pilot drill required	yes, pilot and co-pilot drill
Colour ring	green
Type of product	Jobber drill