Garant

Solid carbide HPC deep-hole drill plain shank DIN 6535 HA 50×D, TiAlN, ⌀ DC: 6,5 mm

Order data

Order number	123750 6,5
GTIN	4045197498359
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 ⌀.
Note:
Flute length $L_C = L_2 + 1.5 \times D_C$.
To achieve good process reliability with 40×D and 50×D deep-hole drills it is absolutely essential to drill 6×D pilot hole with a No. 122736 and a 20×D 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 ⌀: fg6
Number of cutting edges Z: 2
Tolerance nominal ⌀: fg6
recommended maximum drilling depth L_2: 340.3 mm
Overall length L: 395 mm
Shank ⌀ D_s: 8 mm
Feed f in steel < 900 N/mm²: 0.1 mm/rev.

Technical description

Flute length L_c	350 mm
Feed f in steel < 900 N/mm²	0.1 mm/rev.

Nominal ⌀ D_C	6.5 mm
Number of cutting edges Z	2
Tolerance nominal ⌀	fg6
Shank ⌀ D_s	8 mm
Overall length L	395 mm
Standard	Manufacturer's standard
recommended maximum drilling depth L_2	340.3 mm
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	50×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 and co-pilot drill
Colour ring	green
Type of product	Jobber drill