Garant

Solid carbide drill plain shank DIN 6535 HA 180°, TiAlN, ⌀ DC m7: 17,8mm

Order data

Order number	122793 17,8
GTIN	4062406092399
Item class	11E

Description

Version:
Special point geometry for generating **180° flat-bottomed holes.** Low radial forces even when spot drilling on faces with up to 15° slope. Flute geometry for optimum chip evacuation. With 4 guide chamfers to stabilise the drill in the hole.
Advantage:
The 180° point angle permits drilling and counterboring in a single operation.
Recommendation:
When using the solid carbide 180° drill it is absolutely essential for process reliability:
- **When spot drilling on flat surfaces to drill a pilot hole 1×D using pilot drill No. 122736.**
- **When spot drilling on sloping surfaces up to max. 15° : reduce the feed rate f to 25% of the stated value. After spot drilling, the normal feed rate value can be used.**

Note:
Flute length $L_C = L_2 + 1.5 \times D_C$.
Form HB and HE supplied at the same price as HA.
Form **HB:** order with **No. 122793 + 129100HB** .
Form **HE:** order with **No. 122793 + 129100HE**.
180° solid carbide drills for machining aluminium available on request.
Not suitable for generating counterbores for socket-head screws to DIN974-1.

Technical description

Standard	Manufacturer's standard
Number of cutting edges Z	2
Nominal ⌀ D_C	17.8 mm
recommended maximum drilling depth L_2	64.3 mm

Flute length L_c	91 mm
Feed f in steel < 900 N/mm²	0.2 mm/rev.
Overall length L	141 mm
Shank ⌀ D_s	18 mm
Tolerance nominal ⌀	m7
Shank tolerance	h6
Coating	TiAlN
Tool material	Solid carbide
Version	5×D
Point angle	180 degrees
Shank	DIN 6535 HA to h6
Use for drilling	limited convexity
Use for drilling	limited cross-drilling
Use for drilling	limited oblique spot drilling
Through-coolant	yes, with 25 bar
Pilot drill required	yes, pilot drill
Semi-Standard	yes
Colour ring	green
Type of product	Jobber drill

User data

	Suitability	V_c	ISO code
Steel < 500 N/mm²	suitable	85 m/min	P
Steel < 750 N/mm²	suitable	75 m/min	P
Steel < 900 N/mm²	suitable	60 m/min	P
Steel < 1100 N/mm²	suitable	50 m/min	P
INOX < 900 N/mm²	suitable only under restricted conditions	45 m/min	M
GG(G)	suitable	90 m/min	K

Uni	suitable
wet maximum	suitable
wet minimum	suitable
Air	suitable

Services

Shank grinding Type HB	129100 HB
Shank grinding Type HE	129100 HE