

**Garant**
**Solid carbide drill plain shank DIN 6535 HA 180°, TiAlN, Ø DC m7: 6,9mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 122793 6,9    |
| GTIN         | 4045197744951 |
| 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 |
| Shank Ø D <sub>s</sub>                  | 8 mm                    |
| Nominal Ø D <sub>c</sub>                | 6.9 mm                  |
| Feed f in steel < 900 N/mm <sup>2</sup> | 0.12 mm/rev.            |

|  |                               |
|--|-------------------------------|
| Tolerance nominal $\varnothing$          | m7                            |
| Flute length $L_c$                       | 53 mm                         |
| Shank tolerance                          | h6                            |
| Number of cutting edges Z                | 2                             |
| Overall length L                         | 91 mm                         |
| recommended maximum drilling depth $L_2$ | 42.7 mm                       |
| Coating                                  | TiAlN                         |
| Tool material                            | Solid carbide                 |
| Version                                  | 5xD                           |
| 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/mm <sup>2</sup>  | suitable                                  | 85 m/min | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable                                  | 75 m/min | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable                                  | 60 m/min | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable                                  | 50 m/min | P        |
| INOX < 900 N/mm <sup>2</sup>   | 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 |
| <b>Services</b> |          |

|                        |           |
|------------------------|-----------|
| Shank grinding Type HE | 129100 HE |
| Shank grinding Type HB | 129100 HB |