

Garant

Solid carbide HPC drill Weldon shank DIN 6535 HB, DLC, Ø DC h7: 6,1mm



Order data

| | |
|--------------|---------------|
| Order number | 123179 6,1 |
| GTIN | 4045197759894 |
| Item class | 11E |

Description

Version:

DLC coating sp^2 of the latest generation with **low coefficient of friction** results in **outstanding chip clearance**. For **high-performance milling** of **aluminium materials**. **High roundness** and **alignment accuracy of the deep hole**, thanks to **6 guide chamfers**.

Note:

Flute length $L_c = L_2 + 1.5 \times D_c$.

For process reliability when using the 12xD deep-hole drill, an initial centre drilling with No. 121068 – 121130 is necessary.

Technical description

| | |
|--|-------------------------|
| Overall length L | 146 mm |
| Tolerance nominal Ø | h7 |
| Shank tolerance | h6 |
| Nominal Ø D_c | 6.1 mm |
| Shank Ø D_s | 8 mm |
| Feed f in aluminium short-chipping | 0.45 mm/rev. |
| Flute length L_c | 108 mm |
| Number of cutting edges Z | 2 |
| Standard | Manufacturer's standard |
| recommended maximum drilling depth L_2 | 98.9 mm |
| Coating | DLC |

| | |
|--------------------|-------------------|
| Tool material | solid carbide |
| Version | 12xD |
| Type | W |
| Point angle | 135 degrees |
| Shank | DIN 6535 HB to h6 |
| Through-coolant | Yes, with 25 bar |
| Machining strategy | HPC |
| Semi-Standard | yes |
| Colour ring | yellow |
| Type of product | Jobber drill |

User data

| | Suitability | V _c | ISO code |
|----------------------------|-------------|----------------|----------|
| Alu plastics | suitable | 250 m/min | N |
| Aluminium (short chipping) | suitable | 280 m/min | N |
| Alu > 10% Si | suitable | 245 m/min | N |
| PMMA acrylic | suitable | 105 m/min | N |
| PEEK | suitable | 85 m/min | N |
| PVDF GF20 | suitable | 60 m/min | N |
| PA 66 GF30 | suitable | 55 m/min | N |
| PEEK GF30 | suitable | 50 m/min | N |
| PTFE CF25 | suitable | 55 m/min | N |
| Cu | suitable | 120 m/min | N |
| CuZn | suitable | 150 m/min | N |
| GRP | suitable | 55 m/min | N |
| CRP | suitable | 55 m/min | N |
| wet maximum | suitable | | |
| wet minimum | suitable | | |

