

**Garant**
**Solid carbide HPC drill Weldon shank DIN 6535 HB, DLC, Ø DC h7: 15,8mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 123179 15,8   |
| GTIN         | 4045197760463 |
| 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**

|  |                         |
|--|-------------------------|
| Number of cutting edges Z                | 2                       |
| Standard                                 | Manufacturer's standard |
| Feed f in aluminium short-chipping       | 0.65 mm/rev.            |
| Shank tolerance                          | h6                      |
| Flute length $L_c$                       | 208 mm                  |
| Tolerance nominal Ø                      | h7                      |
| Nominal Ø $D_c$                          | 15.8 mm                 |
| Shank Ø $D_s$                            | 16 mm                   |
| Overall length L                         | 260 mm                  |
| recommended maximum drilling depth $L_2$ | 184.3 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 <sub>c</sub> | 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    |                |          |

