

Garant
Solid carbide HPC drill, plain shank DIN 6535 HA, DLC, Ø DC h7: 17,5 mm

Order data

Order number	123178 17,5
GTIN	4045197755797
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**.

Recommendation:
Maximum drilling depth:

flute length (see table) less $1.5 \times$ nominal Ø.

Note:

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

For process reliability when using the $12 \times D$ drill, an initial centre drilling with NC spotting drills No. 121068– 121130 is necessary.

Form HB and HE are supplied at the same price as HA.

Order form **HB**: with **No. 123179**.

Order form **HE**: with **No. 123178 + 129100HE**.

Standard: Manufacturer's standard

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

Tolerance nominal Ø: h7

recommended maximum drilling depth L_2 : 207.8 mm

Overall length L: 285 mm

Shank Ø D_s : 18 mm

Feed f in aluminium short-chipping: 0.7 mm/rev.

Technical description

Flute length L_c	234 mm
Overall length L	285 mm

Number of cutting edges Z	2
Feed f in aluminium short-chipping	0.7 mm/rev.
Nominal $\varnothing D_c$	17.5 mm
Tolerance nominal $\varnothing$	h7
Shank $\varnothing D_s$	18 mm
Shank tolerance	h6
Standard	Manufacturer's standard
recommended maximum drilling depth L ₂	207.8 mm
Coating	DLC
Tool material	solid carbide
	12xD
Type	W
Point angle	135 °
Shank	DIN 6535 HA 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		
Services			

Shank grinding Type HE

129100 HE