

Garant

Solid carbide HPC drill, plain shank DIN 6535 HA, DLC, Ø DC h7: 3,8mm



Order data

Order number	123178 3,8
GTIN	4045197754943
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 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**.

Technical description

Standard	Manufacturer's standard
Flute length L_c	64 mm
Number of cutting edges Z	2
Nominal $\varnothing D_c$	3.8 mm
Shank tolerance	h6
Tolerance nominal \varnothing	h7
Overall length L	102 mm
Feed f in aluminium short-chipping	0.35 mm/rev.
Shank $\varnothing D_s$	6 mm

recommended maximum drilling depth L ₂	58.3 mm
Coating	DLC
Tool material	solid carbide
Version	12×D
Type	W
Point angle	135 degrees
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
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