

Garant

Solid carbide HPC drill, plain shank DIN 6535 HA, DLC, Ø DC h7: 13,8mm



Order data

| | |
|--------------|---------------|
| Order number | 123178 13,8 |
| GTIN | 4045197755681 |
| 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

| | |
|------------------------------------|-------------------------|
| Feed f in aluminium short-chipping | 0.65 mm/rev. |
| Overall length L | 230 mm |
| Tolerance nominal Ø | h7 |
| Shank tolerance | h6 |
| Nominal Ø D_c | 13.8 mm |
| Shank Ø D_s | 14 mm |
| Flute length L_c | 182 mm |
| Number of cutting edges Z | 2 |
| Standard | Manufacturer's standard |

| | |
|---|-------------------|
| recommended maximum drilling depth L ₂ | 161.3 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 |
|------------------------|-----------|