

## Garant

### Solid carbide drill plain shank DIN 6535 HA 180°, TiAlN, Ø DC m7: 3,0-Xmm



#### Order data

|              |               |
|--------------|---------------|
| Order number | 122793 3,0-X  |
| GTIN         | 4062406200473 |
| Item class   | 11E           |

#### Description

##### Version:

Special point geometry for generating **180° flat-bottomed holes**. Low radial forces even when spot drilling on faces with up to 15° slope. Flute geometry for optimum chip evacuation. With 4 guide chamfers to stabilise the drill in the hole.

##### Advantage:

**The 180° point angle** permits drilling and counterboring in a single operation.

##### Recommendation:

When using the solid carbide 180° drill it is absolutely essential for process reliability:

- **When spot drilling on flat surfaces to drill a pilot hole 1×D using pilot drill No. 122736.**
- **When spot drilling on sloping surfaces up to max. 15° : reduce the feed rate f to 25% of the stated value. After spot drilling, the normal feed rate value can be used.**

##### Note:

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

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

Form **HB**: order with **No. 122793 + 129100HB** .

Form **HE**: order with **No. 122793 + 129100HE**.

180° solid carbide drills for machining aluminium available on request.

**Not** suitable for generating counterbores for socket-head screws to DIN974-1. Delivery time: 8 weeks

Minimum order quantity: 3 pcs.

Items made to order for a specific customer: Cancellation only up to a maximum of 3 working days after receipt of order acknowledgement. Items cannot be returned. We reserve the right to over or under deliver by +/-10% (min. 1 pc).

#### Technical description

|         |            |
|---------|------------|
| Ø range | 3 - 3.7 mm |
|---------|------------|

|                                 |                               |
|---------------------------------|-------------------------------|
| Shank $\varnothing D_s$         | 6 mm                          |
| Standard                        | Manufacturer's standard       |
| Overall length L                | 66 mm                         |
| Tolerance nominal $\varnothing$ | m7                            |
| Number of cutting edges Z       | 2                             |
| Flute length $L_c$              | 28 mm                         |
| Coating                         | TiAlN                         |
| Tool material                   | Solid carbide                 |
| Version                         | 5xD                           |
| Point angle                     | 180 degrees                   |
| Shank                           | DIN 6535 HA to h6             |
| Use for drilling                | limited convexity             |
| Use for drilling                | limited cross-drilling        |
| Use for drilling                | limited oblique spot drilling |
| Through-coolant                 | yes, with 25 bar              |
| Pilot drill required            | yes, pilot drill              |
| Semi-Standard                   | yes                           |
| Colour ring                     | green                         |
| Type of product                 | Jobber drill                  |

## User data

|                                | Suitability                               | $V_c$    | ISO code |
|--------------------------------|---|----------|----------|
| Steel < 500 N/mm <sup>2</sup>  | suitable                                  | 85 m/min | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable                                  | 75 m/min | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable                                  | 60 m/min | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable                                  | 50 m/min | P        |
| INOX < 900 N/mm <sup>2</sup>   | suitable only under restricted conditions | 45 m/min | M        |
| GG(G)                          | suitable                                  | 90 m/min | K        |

|             |          |
|-------------|----------|
| Uni         | suitable |
| wet maximum | suitable |
| wet minimum | suitable |
| Air         | suitable |