

Garant
Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 6mm

Order data

| | |
|--------------|---------------|
| Order number | 123302 6 |
| GTIN | 4045197459183 |
| Item class | 11E |

Description
Version:

Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry**.

Particularly high alignment accuracy due to **4 guide chamfers** which stabilise the drill even at extreme depths!

Convex cutting edges with honed edges and special flute profile for **short chips**, even on long chipping materials.

Advantage:

High process reliability and surface quality of the hole.

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 or 3xD pilot drilling operation with No. 122736 is necessary.

NEW GENERATION AVAILABLE!

Recommended successor products are No. 123226 and 123236.

Technical description

| | |
|--|--------------|
| Number of cutting edges Z | 2 |
| Flute length L_c | 78 mm |
| Nominal $\varnothing D_c$ | 6 mm |
| Shank tolerance | h6 |
| Feed f in steel < 1100 N/mm ² | 0.15 mm/rev. |
| Tolerance nominal \varnothing | h7 |
| Shank $\varnothing D_s$ | 6 mm |

| | |
|---|-------------------------|
| Overall length L | 116 mm |
| Standard | Manufacturer's standard |
| recommended maximum drilling depth L ₂ | 69 mm |
| Coating | TiAlN |
| Tool material | Solid carbide |
| Version | 12xD |
| Point angle | 135 degrees |
| Shank | DIN 6535 HB to h6 |
| Through-coolant | yes, with 25 bar |
| Machining strategy | HPC |
| Pilot drill required | yes, pilot drill |
| Semi-Standard | yes |
| Colour ring | green |
| Type of product | Jobber drill |

User data

| | Suitability | V _c | ISO code |
|--------------------------------|---|----------------|----------|
| Aluminium (short chipping) | suitable only under restricted conditions | 180 m/min | N |
| Alu > 10% Si | suitable only under restricted conditions | 140 m/min | N |
| Steel < 500 N/mm ² | suitable only under restricted conditions | 110 m/min | P |
| Steel < 750 N/mm ² | suitable | 90 m/min | P |
| Steel < 900 N/mm ² | suitable | 80 m/min | P |
| Steel < 1100 N/mm ² | suitable | 50 m/min | P |
| Steel < 1400 N/mm ² | suitable | 35 m/min | P |
| INOX < 900 N/mm ² | suitable only under restricted conditions | 40 m/min | M |

| | | | |
|------------------------------|---|----------|---|
| INOX > 900 N/mm ² | suitable only under restricted conditions | 35 m/min | M |
| GG(G) | suitable | 70 m/min | K |
| Uni | suitable | | |
| wet maximum | suitable | | |