Garant

Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, ∅ h7: 13,8 mm

Order data

Order number	123302 13,8
GTIN	4045197647030
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.
Recommendation:
Maximum drilling depth:
clamping slot length (see table) less 1.5×nominal ∅.
Note:
For process reliability when using the 12×D deep-hole drill, an initial centre drilling with No. 121068– 121130 or 3×D pilot drilling operation with No. 122736 is necessary.
NEW GENERATION AVAILABLE!
Recommended successor products are No. 123226 and 123236.
Tool material: Solid carbide
Drill depth up to: 12×D
Point angle: 135 degrees
Skaft: DIN 6535 HB to h6
Through-coolant: yes, with 25 bar
Machining strategy: HPC
Norm: Manufacturer's standard
Tolerance nominal ∅: h7
Number of cutting edges Z: 2
Tolerance nominal ∅: h7
Flute length: 182 mm
Overall length L_{tot}: 230 mm
Shank ∅: 14 mm

Feed f in steel < 1100 N/mm^2: 0.26 mm/rev.

Technical description

Type	
Colour ring	green
Hole tolerance	
Through-coolant	yes, with 25 bar
Helix angle	degrees
Use for drilling	
Machining strategy	HPC
Coating	TiAlN
Drill depth up to	12×D
Cutting direction	
Point angle	135 degrees
Tool material	Solid carbide
Pilot drill required	yes, pilot drill
Skaft	DIN 6535 HB to h6
Series	
Type of product	