Garant

Solid carbide HPC drill, plain shank DIN 6535 HB, TiAlN, Ø DC h7: 7mm

Order data

Order number	123302 7
GTIN	4045197459237
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 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.

Technical description

Nominal Ø D_C	7 mm
Feed f in steel < 1100 N/mm^2	0.15 mm/rev.
Number of cutting edges Z	2
Shank tolerance	h6
Flute length L_c	108 mm
Tolerance nominal Ø	h7
Shank Ø D_s	8 mm

Overall length L	146 mm
Standard	Manufacturer's standard
recommended maximum drilling depth L_2	97.5 mm
Coating	TiAlN
Tool material	Solid carbide
Version	12×D
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/mm²	suitable only under restricted conditions	110 m/min	P
Steel < 750 N/mm²	suitable	90 m/min	P
Steel < 900 N/mm²	suitable	80 m/min	P
Steel < 1100 N/mm²	suitable	50 m/min	P
Steel < 1400 N/mm²	suitable	35 m/min	P
INOX < 900 N/mm²	suitable only under restricted conditions	40 m/min	M

INOX > 900 N/mm²	suitable only under restricted conditions	35 m/min	M
GG(G)	suitable	70 m/min	K
Uni	suitable		
wet maximum	suitable		