Garant

# Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, ∅ h7: 7,5 mm

## Order data

| | |
|---|---|
| Order number | 123302 7,5 |
| GTIN | 4045197459244 |
| 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.**
Norm: Manufacturer's standard
Tolerance nominal ∅: h7
Number of cutting edges Z: 2
Tolerance nominal ∅: h7
Flute length: 108 mm
Overall length $L_{tot}$: 146 mm
Shank ∅: 8 mm
Feed f in steel < 1100 N/mm$^2$: 0.15 mm/rev.

## Technical description

| | |
|---|---|
| Nominal ∅ | 7.5 mm |
| Feed f in steel < 1100 N/mm$^2$ | 0.15 mm/rev. |
| Number of cutting edges Z | 2 |
| Flute length | 108 mm |
| Shank tolerance | h6 |
| Tolerance nominal ∅ | h7 |
| Shank ∅ | 8 mm |
| Overall length $L_{tot}$ | 146 mm |
| Norm | Manufacturer's standard |
| recommended maximum drilling depth | 96.8 mm |
| Coating | TiAlN |
| 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 |
| Pilot drill required | yes, pilot drill |
| Colour ring | green |