

## Garant

**Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 14,5mm**



### Order data

|              |               |
|--------------|---------------|
| Order number | 123102 14,5   |
| GTIN         | 4045197458926 |
| 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  $L_c = L_2 + 1.5 \times D_c$ .

**NEW GENERATION AVAILABLE!**

**Recommended successor products are No. 123026 and 123036.**

### Technical description

|  |              |
|--|--------------|
| Shank tolerance                          | h6           |
| Number of cutting edges Z                | 2            |
| Flute length $L_c$                       | 152 mm       |
| Feed f in steel < 1100 N/mm <sup>2</sup> | 0.26 mm/rev. |
| Nominal Ø $D_c$                          | 14.5 mm      |
| Tolerance nominal Ø                      | h7           |
| Shank Ø $D_s$                            | 16 mm        |
| Overall length L                         | 203 mm       |

|   |                         |
|---|-------------------------|
| Standard  | Manufacturer's standard |
| recommended maximum drilling depth L <sub>2</sub> | 130.3 mm                |
| Coating   | TiAlN                   |
| Tool material                                     | Solid carbide           |
| Version   | 8×D                     |
| Point angle                                       | 135 degrees             |
| Shank   | DIN 6535 HB to h6       |
| Through-coolant                                   | yes, with 25 bar        |
| Machining strategy                                | HPC                     |
| Semi-Standard                                     | yes                     |
| Colour ring                                       | green                   |
| Type of product                                   | Jobber drill            |

## User data

|                                | Suitability                               | V <sub>c</sub> | 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 <sup>2</sup>  | suitable only under restricted conditions | 110 m/min      | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable                                  | 90 m/min       | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable                                  | 80 m/min       | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable                                  | 50 m/min       | P        |
| Steel < 1400 N/mm <sup>2</sup> | suitable                                  | 35 m/min       | P        |
| INOX < 900 N/mm <sup>2</sup>   | suitable only under restricted conditions | 40 m/min       | M        |
| INOX > 900 N/mm <sup>2</sup>   | suitable only under restricted conditions | 35 m/min       | M        |
| GG(G)                          | suitable                                  | 70 m/min       | K        |

|             |          |
|-------------|----------|
| Uni         | suitable |
| wet maximum | suitable |