

Garant
Solid carbide HPC deep hole drill plain shank DIN 6535 HA 20×D, DLC, Ø DC h7: 3mm

Order data

| | |
|--------------|---------------|
| Order number | 123590 3 |
| GTIN | 4045197353955 |
| Item class | 11E |

Description
Version:

Spiral fluted, with **6 guide chamfers** and internal cooling channels. New generation of high performance deep hole drills in the HPC range. **With 135° point angle** and special **h7 cutting edge tolerance** for optimum generation of a deep hole. **High roundness and alignment accuracy of the deep hole.**

Note:

Flute length $L_c = L_2 + 1.5 \times D_c$.

For process reliability when using the 16×D deep hole drill, an initial centre drilling with No. 121068 – 121121 or 4×D pilot drilling operation with pilot drill No. 122606 is necessary. For deep holes greater than 20×D, a pilot hole to the maximum drilling depth with pilot drill No. 122606 is absolutely essential.

The generation of a pilot hole improves process reliability. See also pages 140/141.

Technical description

| | |
|------------------------------------|-------------------------|
| Flute length L_c | 80 mm |
| Number of cutting edges Z | 2 |
| Feed f in aluminium short-chipping | 0.14 mm/rev. |
| Nominal $\varnothing D_c$ | 3 mm |
| Tolerance nominal \varnothing | h7 |
| Shank $\varnothing D_s$ | 6 mm |
| Overall length L | 120 mm |
| Standard | Manufacturer's standard |

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|--|-------------------|
| recommended maximum drilling depth L_2 | 75.5 mm |
| Coating | DLC |
| Tool material | Solid carbide |
| Version | 20xD |
| Point angle | 135 degrees |
| Shank | DIN 6535 HA to h6 |
| Through-coolant | yes, with 40 bar |
| Machining strategy | HPC |
| Pilot drill required | yes, pilot drill |
| Colour ring | yellow |
| Type of product | Jobber drill |

User data

| | Suitability | V_c | ISO code |
|----------------------------|-------------|-----------|----------|
| Aluminium | suitable | 150 m/min | N |
| Aluminium (short chipping) | suitable | 180 m/min | N |
| Alu > 10% Si | suitable | 130 m/min | N |
| PMMA acrylic | suitable | 135 m/min | N |
| PEEK | suitable | 105 m/min | N |
| PVDF GF20 | suitable | 80 m/min | N |
| PA 66 GF30 | suitable | 70 m/min | N |
| PEEK GF30 | suitable | 65 m/min | N |
| PTFE CF25 | suitable | 70 m/min | N |
| Cu | suitable | 90 m/min | N |
| CuZn | suitable | 100 m/min | N |
| GRP | suitable | 70 m/min | N |
| CRP | suitable | 70 m/min | N |
| wet maximum | suitable | | |

wet minimum

suitable