

**Garant**
**Solid carbide HPC deep hole drill plain shank DIN 6535 HA 16×D, DLC, Ø DC h7: 7,8mm**

**Order data**

Order number	123588 7,8
GTIN	4045197352439
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**

Number of cutting edges Z	2
Nominal Ø D <sub>c</sub>	7.8 mm
Feed f in aluminium short-chipping	0.28 mm/rev.
Flute length L <sub>c</sub>	140 mm
Tolerance nominal Ø	h7
Shank Ø D <sub>s</sub>	8 mm
Overall length L	180 mm
Standard	Manufacturer's standard

recommended maximum drilling depth $L_2$	128.3 mm
Coating	DLC
Tool material	Solid carbide
Version	16xD
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	160 m/min	N
Aluminium (short chipping)	suitable	190 m/min	N
Alu > 10% Si	suitable	140 m/min	N
PMMA acrylic	suitable	150 m/min	N
PEEK	suitable	120 m/min	N
PVDF GF20	suitable	90 m/min	N
PA 66 GF30	suitable	80 m/min	N
PEEK GF30	suitable	70 m/min	N
PTFE CF25	suitable	80 m/min	N
Cu	suitable	90 m/min	N
CuZn	suitable	115 m/min	N
GRP	suitable	80 m/min	N
CRP	suitable	80 m/min	N
wet maximum	suitable		

wet minimum

suitable