

## Garant

### Solid carbide HPC deep hole drill plain shank DIN 6535 HA 30×D, DLC, Ø DC h7: 4,5mm



#### Order data

|              |               |
|--------------|---------------|
| Order number | 123595 4,5    |
| GTIN         | 4045197354969 |
| 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

|                                    |                         |
|------------------------------------|-------------------------|
| Feed f in aluminium short-chipping | 0.19 mm/rev.            |
| Number of cutting edges Z          | 2                       |
| Flute length $L_c$                 | 165 mm                  |
| Nominal $\varnothing D_c$          | 4.5 mm                  |
| Tolerance nominal $\varnothing$    | h7                      |
| Shank $\varnothing D_s$            | 6 mm                    |
| Overall length L                   | 215 mm                  |
| Standard                           | Manufacturer's standard |

|  |                   |
|--|-------------------|
| recommended maximum drilling depth $L_2$ | 158.3 mm          |
| Coating                                  | DLC               |
| Tool material                            | Solid carbide     |
| Version                                  | 30×D              |
| 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    | 120 m/min | N        |
| Aluminium (short chipping) | suitable    | 150 m/min | N        |
| Alu > 10% Si               | suitable    | 110 m/min | N        |
| PMMA acrylic               | suitable    | 120 m/min | N        |
| PEEK                       | suitable    | 95 m/min  | N        |
| PVDF GF20                  | suitable    | 70 m/min  | N        |
| PA 66 GF30                 | suitable    | 65 m/min  | N        |
| PEEK GF30                  | suitable    | 55 m/min  | N        |
| PTFE CF25                  | suitable    | 65 m/min  | N        |
| Cu                         | suitable    | 70 m/min  | N        |
| CuZn                       | suitable    | 80 m/min  | N        |
| GRP                        | suitable    | 65 m/min  | N        |
| CRP                        | suitable    | 65 m/min  | N        |
| wet maximum                | suitable    |           |          |

wet minimum

suitable