Garant

Solid carbide HPC deep hole drill plain shank DIN 6535 HA 30×D, DLC, ⌀ DC h7: 12mm

Order data

Order number	123595 12
GTIN	4045197355164
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

Nominal ⌀ D_C	12 mm
Feed f in aluminium short-chipping	0.34 mm/rev.
Flute length L_c	380 mm
Number of cutting edges Z	2
Tolerance nominal ⌀	h7
Shank ⌀ D_s	12 mm
Overall length L	430 mm
Standard	Manufacturer's standard

recommended maximum drilling depth L_2	362 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