Garant

Solid carbide HPC deep hole drill plain shank DIN 6535 HA 20×D, TiAlN, ⌀ DC h7: 2,4mm

Order data

Order number	123690 2,4
GTIN	4045197320193
Item class	11E

Description

Version:
Spiral fluted, with **4 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. 122736 is necessary. For deep holes greater than 20×D, a pilot hole to the maximum drilling depth with pilot drill No. 122736 is absolutely essential. **The generation of a pilot hole improves process reliability.** See also pages 140/141.

Technical description

Nominal ⌀ D_C	2.4 mm
Feed f in steel < 900 N/mm^2	0.06 mm/rev.
Flute length L_c	70 mm
Number of cutting edges Z	2
Tolerance nominal ⌀	h7
Shank ⌀ D_s	4 mm
Overall length L	112 mm

Standard	Manufacturer's standard
recommended maximum drilling depth L_2	66.4 mm
Coating	TiAlN
Tool material	Solid carbide
Version	20×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	green
Type of product	Jobber drill

User data

	Suitability	V_c	ISO code
Steel < 500 N/mm²	suitable	105 m/min	P
Steel < 750 N/mm²	suitable	90 m/min	P
Steel < 900 N/mm²	suitable	90 m/min	P
Steel < 1100 N/mm²	suitable	90 m/min	P
Steel < 1400 N/mm²	suitable	70 m/min	P
INOX < 900 N/mm²	suitable	50 m/min	M
INOX > 900 N/mm²	suitable only under restricted conditions	45 m/min	M
GG(G)	suitable	95 m/min	K
Uni	suitable		
wet maximum	suitable		