

Garant

Solid carbide HPC deep-hole drill plain shank DIN 6535 HA 25×D, TiAlN, Ø DC h7: 6,8mm



Order data

Order number	123693 6,8
GTIN	4045197454157
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:

For process reliability when using the 16×D deep hole drill, an initial centre drilling with No. 121068 – 121130 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 129/130.

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

Standard: Manufacturer's standard

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

recommended maximum drilling depth L_2 : 189.8 mm

Tolerance nominal Ø: h7

Overall length L: 240 mm

Shank Ø D_s : 8 mm

Feed f in steel < 900 N/mm²: 0.14 mm/rev.

Technical description

Nominal Ø D_c	6.8 mm
Flute length L_c	200 mm

Feed f in steel < 900 N/mm ²	0.14 mm/rev.
Number of cutting edges Z	2
Tolerance nominal Ø	h7
Shank Ø D _s	8 mm
Overall length L	240 mm
Standard	Manufacturer's standard
recommended maximum drilling depth L ₂	189.8 mm
Coating	TiAlN
Tool material	Solid carbide
Version	25xD
Point angle	135 °
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/mm ²	suitable	95 m/min	P
Steel < 750 N/mm ²	suitable	80 m/min	P
Steel < 900 N/mm ²	suitable	80 m/min	P
Steel < 1100 N/mm ²	suitable	80 m/min	P
Steel < 1400 N/mm ²	suitable	65 m/min	P
INOX < 900 N/mm ²	suitable	50 m/min	M
INOX > 900 N/mm ²	suitable only under restricted conditions	45 m/min	M
GG(G)	suitable	85 m/min	K

Uni	suitable
wet maximum	suitable