

**Garant**
**Solid carbide HPC deep-hole drill plain shank DIN 6535 HA 25×D, TiAlN, Ø DC h7: 9,8mm**

**Order data**

Order number	123693 9,8
GTIN	4045197454188
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  $L_2$ : 253.3 mm

Tolerance nominal Ø: h7

Overall length L: 310 mm

Shank Ø  $D_s$ : 10 mm

Feed f in steel < 900 N/mm<sup>2</sup>: 0.16 mm/rev.

**Technical description**

Number of cutting edges Z	2
Nominal Ø $D_c$	9.8 mm

Flute length $L_c$	268 mm
Feed $f$ in steel $< 900 \text{ N/mm}^2$	0.16 mm/rev.
Tolerance nominal $\varnothing$	h7
Shank $\varnothing D_s$	10 mm
Overall length $L$	310 mm
Standard	Manufacturer's standard
recommended maximum drilling depth $L_2$	253.3 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 $< 500 \text{ N/mm}^2$	suitable	95 m/min	P
Steel $< 750 \text{ N/mm}^2$	suitable	80 m/min	P
Steel $< 900 \text{ N/mm}^2$	suitable	80 m/min	P
Steel $< 1100 \text{ N/mm}^2$	suitable	80 m/min	P
Steel $< 1400 \text{ N/mm}^2$	suitable	65 m/min	P
INOX $< 900 \text{ N/mm}^2$	suitable	50 m/min	M
INOX $> 900 \text{ N/mm}^2$	suitable only under restricted conditions	45 m/min	M
GG(G)	suitable	85 m/min	K

Uni	suitable
wet maximum	suitable