

Garant

Solid carbide HPC co-pilot drill, plain shank DIN 6535 HA 20×D, TiAlN, Ø DC: 4mm



Order data

| | |
|--------------|---------------|
| Order number | 123691 4 |
| GTIN | 4045197569110 |
| Item class | 11E |

Description

Version:

Helical fluted, with **4 guide chamfers** and internal coolant holes. New generation of high performance co-pilot drills in the HPC range. **With 138° point angle** and special **j6 cutting edge tolerance** for optimum generation of a co-pilot hole. **High roundness and alignment accuracy of the co-pilot hole.**

Note:

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

To achieve good process reliability with 40×D and 50×D deep hole drills, it is absolutely essential to drill a pilot hole to the maximum drilling depth with a pilot drill No. 122736 and a 20×D co-pilot hole with a co-pilot drill No. 123691.

The generation of a pilot hole improves process reliability. See also pages 140/141.

Technical description

| | |
|---|-------------------------|
| Nominal Ø D _c | 4 mm |
| Flute length L _c | 90 mm |
| Number of cutting edges Z | 2 |
| Feed f in steel < 900 N/mm ² | 0.06 mm/rev. |
| Tolerance nominal Ø | j6 |
| Shank Ø D _s | 6 mm |
| Overall length L | 130 mm |
| Standard | Manufacturer's standard |

| | |
|--|-------------------|
| recommended maximum drilling depth L_2 | 84 mm |
| Coating | TiAlN |
| Tool material | Solid carbide |
| Version | 20xD |
| Point angle | 138 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/mm ² | suitable | 105 m/min | P |
| Steel < 750 N/mm ² | suitable | 90 m/min | P |
| Steel < 900 N/mm ² | suitable | 90 m/min | P |
| Steel < 1100 N/mm ² | suitable | 90 m/min | P |
| Steel < 1400 N/mm ² | suitable | 70 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 | 95 m/min | K |
| Uni | suitable | | |
| wet maximum | suitable | | |