

Garant

Solid carbide HPC deep-hole drill plain shank DIN 6535 HA 25×D, TiAlN, Ø DC h7: 4,2mm



Order data

| | |
|--------------|---------------|
| Order number | 123693 4,2 |
| GTIN | 4045197454126 |
| 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 : 113.7 mm

Tolerance nominal Ø: h7

Overall length L: 160 mm

Shank Ø D_s : 6 mm

Feed f in steel < 900 N/mm²: 0.1 mm/rev.

Technical description

| | |
|---------------------------|--------|
| Number of cutting edges Z | 2 |
| Nominal Ø D_c | 4.2 mm |

| | |
|------------------------------------------|-------------------------|
| Flute length L_c | 120 mm |
| Feed f in steel $< 900 \text{ N/mm}^2$ | 0.1 mm/rev. |
| Tolerance nominal \varnothing | h7 |
| Shank $\varnothing D_s$ | 6 mm |
| Overall length L | 160 mm |
| Standard | Manufacturer's standard |
| recommended maximum drilling depth L_2 | 113.7 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 |