

Garant

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

Order data

| | |
|--------------|---------------|
| Order number | 123693 8 |
| GTIN | 4045197320698 |
| 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 – 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.

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

Technical description

| | |
|---|-------------------------|
| Nominal Ø D _c | 8 mm |
| Feed f in steel < 900 N/mm ² | 0.14 mm/rev. |
| Number of cutting edges Z | 2 |
| Flute length L _c | 220 mm |
| Tolerance nominal Ø | h7 |
| Shank Ø D _s | 8 mm |
| Overall length L | 260 mm |
| Standard | Manufacturer's standard |

| | |
|--|-------------------|
| recommended maximum drilling depth L_2 | 208 mm |
| Coating | TiAlN |
| Tool material | Solid carbide |
| Version | 25×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/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 | | |