Garant

Solid carbide HPC deep hole drill plain shank DIN 6535 HA 40×D, TiAlN, ⌀ DC: 6,5mm

Order data

Order number	123740 6,5
GTIN	4045197498182
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 **fg6 cutting edge tolerance** for optimum generation of deep holes. **High roundness and alignment accuracy of the deep 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

Flute length L_c	300 mm
Feed f in steel < 900 N/mm^2	0.1 mm/rev.
Nominal ⌀ D_C	6.5 mm
Number of cutting edges Z	2
Tolerance nominal ⌀	fg6
Shank ⌀ D_s	8 mm
Overall length L	345 mm
Standard	Manufacturer's standard

recommended maximum drilling depth L_2	290.3 mm
Coating	TiAlN
Tool material	Solid carbide
Version	40×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 and co-pilot drill
Colour ring	green
Type of product	Jobber drill

User data

	Suitability	V_c	ISO code
Steel < 500 N/mm²	suitable	75 m/min	P
Steel < 750 N/mm²	suitable	60 m/min	P
Steel < 900 N/mm²	suitable	60 m/min	P
Steel < 1100 N/mm²	suitable	60 m/min	P
Steel < 1400 N/mm²	suitable	50 m/min	P
INOX < 900 N/mm²	suitable	40 m/min	M
INOX > 900 N/mm²	suitable only under restricted conditions	35 m/min	M
GG(G)	suitable	65 m/min	K
Uni	suitable		
wet maximum	suitable		