

Garant

Solid carbide HPC drill, plain shank DIN 6535 HA, DLC, Ø DC h7: 3,0-Xmm



Order data

| | |
|--------------|---------------|
| Order number | 123178 3,0-X |
| GTIN | 4062406080228 |
| Item class | 11E |

Description

Version:

DLC coating sp² of the latest generation with **low coefficient of friction** results in **outstanding chip clearance**. For **high-performance milling** of **aluminium materials**. **High roundness** and **alignment accuracy of the deep hole**, thanks to **6 guide chamfers**.

Note:

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

For process reliability when using the 12xD drill, an initial centre drilling with NC spotting drills No. 121068– 121130 is necessary.

Form HB and HE are supplied at the same price as HA.

Order form **HB**: with **No. 123179**.

Order form **HE**: with **No. 123178 + 129100HE**. Delivery time: 12 working weeks

Minimum order quantity: 3 pcs

Items made to order for a specific customer:

Cancellation only up to a maximum of 3 working days after receipt of order acknowledgement.

Items cannot be returned. We reserve the right to over-deliver or under-deliver by $\pm 10\%$ (minimum 1 piece).

Technical description

| | |
|------------------------------------|-------------------------|
| Overall length L | 92 mm |
| Feed f in aluminium short-chipping | 0.22 mm/rev. |
| Tolerance nominal Ø | h7 |
| Shank Ø D _s | 6 mm |
| Number of cutting edges Z | 2 |
| Standard | Manufacturer's standard |

| | |
|--------------------|-------------------|
| Flute length L_c | 54 mm |
| Ø range | 3 - 3.75 mm |
| Coating | DLC |
| Tool material | solid carbide |
| Version | 12xD |
| Type | W |
| Point angle | 135 degrees |
| Shank | DIN 6535 HA to h6 |
| Through-coolant | yes, with 25 bar |
| Machining strategy | HPC |
| Semi-Standard | yes |
| Colour ring | yellow |
| Type of product | Jobber drill |

User data

| | Suitability | V_c | ISO code |
|----------------------------|-------------|-----------|----------|
| Alu plastics | suitable | 250 m/min | N |
| Aluminium (short chipping) | suitable | 280 m/min | N |
| Alu > 10% Si | suitable | 245 m/min | N |
| PMMA acrylic | suitable | 105 m/min | N |
| PEEK | suitable | 85 m/min | N |
| PVDF GF20 | suitable | 60 m/min | N |
| PA 66 GF30 | suitable | 55 m/min | N |
| PEEK GF30 | suitable | 50 m/min | N |
| PTFE CF25 | suitable | 55 m/min | N |
| Cu | suitable | 120 m/min | N |
| CuZn | suitable | 150 m/min | N |
| GRP | suitable | 55 m/min | N |

| | | | |
|-------------|----------|----------|---|
| CRP | suitable | 55 m/min | N |
| wet maximum | suitable | | |
| wet minimum | suitable | | |