

Garant
Solid carbide HPC deep hole drill plain shank DIN 6535 HA 40×D, TiAlN, Ø DC: 7,8mm

Order data

| | |
|--------------|---------------|
| Order number | 123740 7,8 |
| GTIN | 4045197498229 |
| 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

| | |
|---|-------------------------|
| Nominal Ø D _c | 7.8 mm |
| Number of cutting edges Z | 2 |
| Feed f in steel < 900 N/mm ² | 0.12 mm/rev. |
| Flute length L _c | 340 mm |
| Tolerance nominal Ø | fg6 |
| Shank Ø D _s | 8 mm |
| Overall length L | 385 mm |
| Standard | Manufacturer's standard |

| | |
|--|-------------------------------|
| recommended maximum drilling depth L_2 | 328.3 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/mm ² | suitable | 75 m/min | P |
| Steel < 750 N/mm ² | suitable | 60 m/min | P |
| Steel < 900 N/mm ² | suitable | 60 m/min | P |
| Steel < 1100 N/mm ² | suitable | 60 m/min | P |
| Steel < 1400 N/mm ² | suitable | 50 m/min | P |
| INOX < 900 N/mm ² | suitable | 40 m/min | M |
| INOX > 900 N/mm ² | suitable only under restricted conditions | 35 m/min | M |
| GG(G) | suitable | 65 m/min | K |
| Uni | suitable | | |
| wet maximum | suitable | | |