Garant

# Solid carbide HPC co-pilot drill, plain shank DIN 6535 HA 20×D, TiAlN, ⌀ DC: 7mm

## Order data

| | |
|---|---|
| Order number | 123691 7 |
| GTIN | 4045197569219 |
| Item class | 11E |

## Description

**Version:**
Helical fluted, with **4 guide chamfers** and internal coolant holes. New generation of high performance co-pilot drills in the HPC range. **With 138° point angle** and special **j6 cutting edge tolerance** for optimum generation of a co-pilot hole. **High roundness and alignment accuracy of the co-pilot 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 ⌀ $D_C$ | 7 mm |
| Flute length $L_c$ | 160 mm |
| Feed f in steel < 900 N/mm² | 0.12 mm/rev. |
| Number of cutting edges Z | 2 |
| Tolerance nominal ⌀ | j6 |
| Shank ⌀ $D_s$ | 8 mm |
| Overall length L | 210 mm |
| Standard | Manufacturer's standard |

| | |
|---|---|
| recommended maximum drilling depth $L_2$ | 149.5 mm |
| Coating | TiAlN |
| Tool material | Solid carbide |
| Version | 20×D |
| Point angle | 138 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/mm² | suitable | 105 m/min | P |
| Steel < 750 N/mm² | suitable | 90 m/min | P |
| Steel < 900 N/mm² | suitable | 90 m/min | P |
| Steel < 1100 N/mm² | suitable | 90 m/min | P |
| Steel < 1400 N/mm² | suitable | 70 m/min | P |
| INOX < 900 N/mm² | suitable | 50 m/min | M |
| INOX > 900 N/mm² | suitable only under restricted conditions | 45 m/min | M |
| GG(G) | suitable | 95 m/min | K |
| Uni | suitable | | |
| wet maximum | suitable | | |