

## Garant

### Solid carbide HPC co-pilot drill, plain shank DIN 6535 HA 20×D, TiAlN, Ø DC: 8mm



#### Order data

Order number	123691 8
GTIN	4045197569240
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

Flute length $L_c$	180 mm
Nominal $\varnothing D_c$	8 mm
Feed $f$ in steel $< 900 \text{ N/mm}^2$	0.12 mm/rev.
Number of cutting edges $Z$	2
Tolerance nominal $\varnothing$	j6
Shank $\varnothing D_s$	8 mm
Overall length $L$	230 mm
Standard	Manufacturer's standard

recommended maximum drilling depth $L_2$	168 mm
Coating	TiAlN
Tool material	Solid carbide
Version	20xD
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/mm <sup>2</sup>	suitable	105 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	90 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	90 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	90 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	70 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	50 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable only under restricted conditions	45 m/min	M
GG(G)	suitable	95 m/min	K
Uni	suitable		
wet maximum	suitable		