

**Garant**
**Solid carbide HPC drill, plain shank DIN 6535 HA, DLC, Ø DC h7: 8,5 mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 122306 8,5    |
| GTIN         | 4045197751638 |
| Item class   | 11E           |

**Description**
**Version:**

**DLC coating sp<sup>2</sup>** of the latest generation with **low coefficient of friction** results in **outstanding chip clearance**. For **high-performance milling** of aluminium materials. **High alignment accuracy** and **roundness of the hole**, thanks to **6 guide chamfers**.

Size 1 - 1.5 with 4 guide chamfers.

**Recommendation:**
**Maximum drilling depth:**

flute length (see table) less 1.5×nominal Ø.

**Note:**

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

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

Form **HB**: order with **No. 122307**.

Form **HE**: order with **No. 122306 + 129100HE**.

Standard: DIN 6537 K

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

Tolerance nominal Ø: h7

recommended maximum drilling depth  $L_2$ : 34.3 mm

Overall length L: 89 mm

Shank Ø  $D_s$ : 10 mm

Feed f in aluminium short-chipping: 0.55 mm/rev.

**Technical description**

|                  |       |
|------------------|-------|
| Overall length L | 89 mm |
| Shank Ø $D_s$    | 10 mm |

|  |                   |
|--|-------------------|
| Standard                                 | DIN 6537 K        |
| Tolerance nominal $\varnothing$          | h7                |
| Shank tolerance                          | h6                |
| Nominal $\varnothing D_c$                | 8.5 mm            |
| Feed f in aluminium short-chipping       | 0.55 mm/rev.      |
| Number of cutting edges Z                | 2                 |
| Flute length $L_c$                       | 47 mm             |
| recommended maximum drilling depth $L_2$ | 34.3 mm           |
| Coating                                  | DLC               |
| Tool material                            | solid carbide     |
| Drill depth up to                        | 4xD               |
| 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      |

## Services

|                        |           |
|------------------------|-----------|
| Shank grinding Type HE | 129100 HE |
|------------------------|-----------|