

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


Order data

Order number	122440 8,5
GTIN	4045197048455
Item class	11E

Description

Version:

Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry. Convex cutting edges** with honed edges and special flute profile for **short chips**, even on long chipping materials.

Recommendation:

Maximum drilling depth:

clamping slot length (see table) less $1.5 \times \text{nominal } \varnothing$.

Note:

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

Form **HB**: order with **No. 122445/122505**.

Form **HE**: order with **No. 122440/122500** and **129100HE**.

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

NEW GENERATION AVAILABLE!

Recommended successor products are No. 122415; 122425; 122435 and 122361, as well as 122371.

Machining strategy: HPC

Standard: DIN 6537 K

Tolerance nominal \varnothing : h7

Number of cutting edges Z: 2

Semi-Standard: yes

Tolerance nominal \varnothing : h7

recommended maximum drilling depth L_2 : 34.3 mm

Overall length L: 89 mm

Shank $\varnothing D_s$: 10 mm

Feed f in steel $< 1100 \text{ N/mm}^2$: 0.2 mm/rev.

Technical description

Nominal $\varnothing D_c$	8.5 mm
Flute length L_c	47 mm
Feed f in steel $< 1100 \text{ N/mm}^2$	0.2 mm/rev.
Shank tolerance	h6
Number of cutting edges Z	2
Tolerance nominal \varnothing	h7
Shank $\varnothing D_s$	10 mm
Overall length L	89 mm
Standard	DIN 6537 K
recommended maximum drilling depth L_2	34.3 mm
Semi-Standard	yes
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	4xD
Point angle	140 degrees
Shank	DIN 6535 HA to h6
Through-coolant	no
Machining strategy	HPC
Colour ring	green
Type of product	Jobber drill

Services

Shank grinding Type HE	129100 HE
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