

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

Order data

Order number	122500 8,5
GTIN	4045197050472
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.

Standard: DIN 6537 K

Tolerance nominal \varnothing : h7

Number of cutting edges Z: 2

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
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Feed f in steel < 1100 N/mm ²	0.2 mm/rev.
Flute length L _c	47 mm
Number of cutting edges Z	2
Shank tolerance	h6
Tolerance nominal Ø	h7
Shank Ø D _s	10 mm
Overall length L	89 mm
Standard	DIN 6537 K
recommended maximum drilling depth L ₂	34.3 mm
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	4xD
Point angle	140 degrees
Shank	DIN 6535 HA to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Semi-Standard	yes
Colour ring	green
Type of product	Jobber drill

Services

Shank grinding Type HE	129100 HE
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