

## Garant

### Solid carbide drill IC plain shank unidirectional DIN 6535 HA, Diamond, Ø DC m7: 9 mm



#### Order data

|              |               |
|--------------|---------------|
| Order number | 122532 9      |
| GTIN         | 4045197506924 |
| Item class   | 11Y           |

#### Description

##### Version:

With the latest generation of **crystalline diamond coating sp<sup>3</sup>**, for process reliability in machining **fibre-reinforced composites, CRP, GRP, and graphite. With 90° point angle** and special geometry to **avoid delamination.**

Under optimum conditions of use, the **double flute face** can generate high precision holes (**roundness < 15 µm to base tolerance IT 7**). Low heat generation due to **internal cooling** permits **higher speeds and feeds.**

##### Recommendation:

##### Maximum drilling depth:

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

##### Note:

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

Available in **1/100 sizes** and according to the table.

Tolerance nominal Ø: m7

Number of cutting edges Z: 2

recommended maximum drilling depth  $L_2$ : 47.5 mm

Overall length L: 103 mm

Shank Ø  $D_s$ : 10 mm

Feed f in GRP CRP: 0.15 mm/rev.

#### Technical description

|                           |       |
|---------------------------|-------|
| Number of cutting edges Z | 2     |
| Flute length $L_c$        | 61 mm |
| Nominal Ø $D_c$           | 9 mm  |

|  |                         |
|--|-------------------------|
| Shank tolerance                          | h6                      |
| Feed f in GRP CRP                        | 0.15 mm/rev.            |
| Tolerance nominal $\varnothing$          | m7                      |
| Shank $\varnothing D_s$                  | 10 mm                   |
| Overall length L                         | 103 mm                  |
| recommended maximum drilling depth $L_2$ | 47.5 mm                 |
| Coating                                  | Diamond                 |
| Tool material                            | Solid carbide           |
| Standard                                 | Manufacturer's standard |
| Drill depth up to                        | 5×D                     |
| Point angle                              | 90 degrees              |
| Cutting direction                        | right-hand              |
| Shank                                    | DIN 6535 HA to h6       |
| Through-coolant                          | yes, with 25 bar        |
| Colour ring                              | black                   |
| Type of product                          | Jobber drill            |