

## Garant

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



#### Order data

Order number	122670 8,5
GTIN	4045197056764
Item class	11E

#### Description

##### Version:

**Particularly strong** due to strengthened core and **special profile**. Special point geometry.

**High concentricity** and **long tool life**.

**High bore quality**.

##### Recommendation:

##### Maximum drilling depth:

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

##### 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. 122675**.

Form **HE**: order with **No. 122670 + 129100HE**.

Standard: DIN 6537

Tolerance nominal  $\varnothing$ : h7

Number of cutting edges Z: 2

Tolerance nominal  $\varnothing$ : h7

recommended maximum drilling depth  $L_2$ : 48.3 mm

Overall length L: 103 mm

Shank  $\varnothing D_s$ : 10 mm

Feed f in titanium  $> 850 \text{ N/mm}^2$ : 0.12 mm/rev.

#### Technical description

Nominal $\varnothing D_c$	8.5 mm
Number of cutting edges Z	2

Flute length $L_c$	61 mm
Shank tolerance	h6
Feed $f$ in titanium > 850 N/mm <sup>2</sup>	0.12 mm/rev.
Tolerance nominal $\varnothing$	h7
Shank $\varnothing D_s$	10 mm
Overall length $L$	103 mm
Standard	DIN 6537
recommended maximum drilling depth $L_2$	48.3 mm
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	6xD
Type	FS
Point angle	140 degrees
Shank	DIN 6535 HA to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Semi-Standard	yes
Colour ring	pink
Type of product	Jobber drill

## Services

Shank grinding Type HE	129100 HE
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