

Garant

Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC p6: 8,5 mm



Order data

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|--------------|---------------|
| Order number | 122736 8,5 |
| GTIN | 4045197567215 |
| Item class | 11E |

Description

Version:

Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry**. High roundness and alignment accuracy of the deep hole, thanks to **4 guide chamfers**. Outstanding chip evacuation due to **4 internal cooling channels** from Ø 3.8 mm. Up to 3.7 mm Ø with 2 internal cooling channels. With **140° point angle** and special **j6 cutting edge tolerance** for optimum generation of a pilot hole.

Recommendation:

Maximum drilling depth:

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

Note:

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

For deep-hole drilling deeper than 12×D a pilot hole is recommended, and for deep-hole drilling from 20×D to 30×D it is essential.

The generation of a pilot hole improves process reliability.

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

Form **HB**: order with **No. 122738**.

Form **HE**: order with **No. 122736 + 129100HE**.

Standard: DIN 6537

Tolerance nominal Ø: p6

Number of cutting edges Z: 2

Tolerance nominal Ø: p6

recommended maximum drilling depth L_2 : 48.3 mm

Overall length L: 103 mm

Shank Ø D_s : 10 mm

Feed f in steel < 1100 N/mm²: 0.27 mm/rev.

Technical description

| | |
|--|-------------------|
| Shank tolerance | h6 |
| Number of cutting edges Z | 2 |
| Feed f in steel < 1100 N/mm ² | 0.27 mm/rev. |
| Nominal $\varnothing D_c$ | 8.5 mm |
| Flute length L_c | 61 mm |
| Tolerance nominal \varnothing | p6 |
| 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 | 6×D |
| 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

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