

**Garant**
**Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 8,5 mm**


## Order data

Order number	122765 8,5
GTIN	4045197399052
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:

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

### NEW GENERATION AVAILABLE!

**Recommended successor products are No. 122716 and 122726.**

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

## Technical description

Feed f in steel < $1100 \text{ N/mm}^2$	0.2 mm/rev.
Shank tolerance	h6
Number of cutting edges Z	2

Nominal $\varnothing D_c$	8.5 mm
Flute length $L_c$	61 mm
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	6×D
Point angle	140 degrees
Cutting direction	right-hand
Shank	DIN 6535 HB to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Semi-Standard	yes
Colour ring	green
Type of product	Jobber drill