

## Garant

**Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC m6 (mm or inch): 8,5 mm or inch**



### Order data

|              |               |
|--------------|---------------|
| Order number | 123008 8,5    |
| GTIN         | 4045197569677 |
| 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. **Straight major cutting edges** with honed edges and special flute profile for **short chips**, even on long chipping materials.

#### Recommendation:

##### Maximum drilling depth:

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

##### Note:

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

Form **HB**: order with **No. 123010**.

Form **HE**: order with **No. 123008 + 129100HE**.

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

Standard: Manufacturer's standard

Tolerance nominal Ø: m6

Number of cutting edges Z: 2

Tolerance nominal Ø: m6

recommended maximum drilling depth  $L_2$ : 82.3 mm

Overall length L: 142 mm

Shank Ø  $D_s$ : 10 mm

Feed f in stainless steel > 900 N/mm<sup>2</sup>: 0.15 mm/rev.

### Technical description

|                           |   |
|---------------------------|---|
| Number of cutting edges Z | 2 |
|---------------------------|---|

|  |                         |
|--|-------------------------|
| Flute length $L_c$                                 | 95 mm                   |
| Shank tolerance                                    | h6                      |
| Nominal $\varnothing D_c$                          | 8.5 mm                  |
| Feed $f$ in stainless steel $> 900 \text{ N/mm}^2$ | 0.15 mm/rev.            |
| Tolerance nominal $\varnothing$                    | m6                      |
| Shank $\varnothing D_s$                            | 10 mm                   |
| Overall length $L$                                 | 142 mm                  |
| Standard   | Manufacturer's standard |
| recommended maximum drilling depth $L_2$           | 82.3 mm                 |
| Coating  | TiAlN                   |
| Tool material                                      | Solid carbide           |
| Drill depth up to                                  | 8xD                     |
| Point angle  | 140 degrees             |
| Shank  | DIN 6535 HA to h6       |
| Through-coolant                                    | yes, with 25 bar        |
| Machining strategy                                 | HPC                     |
| Semi-Standard                                      | yes                     |
| Colour ring  | blue                    |
| Type of product                                    | Jobber drill            |

## Services

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