

## Garant

**Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC m6 (mm or inch): 8,6 mm or inch**



### Order data

Order number	123008 8,6
GTIN	4045197569684
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  $L_2$ : 82.1 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

Flute length $L_c$	95 mm
--------------------	-------

Number of cutting edges Z	2
Feed f in stainless steel > 900 N/mm <sup>2</sup>	0.15 mm/rev.
Shank tolerance	h6
Nominal Ø D <sub>c</sub>	8.6 mm
Tolerance nominal Ø	m6
Shank Ø D <sub>s</sub>	10 mm
Overall length L	142 mm
Standard	Manufacturer's standard
recommended maximum drilling depth L <sub>2</sub>	82.1 mm
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	8×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	blue
Type of product	Jobber drill

## Services

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