

Garant
Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC h7: 8,6 mm

Order data

Order number	123101 8,6
GTIN	4045197451835
Item class	11E

Description
Version:

Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry**.

Particularly high alignment accuracy due to **4 guide chamfers** which stabilise the drill even at extreme depths!

Convex cutting edges with honed edges and special flute profile for **short chips**, even on long chipping materials.

Advantage:

High process reliability and surface quality of the hole.

Recommendation:
Maximum drilling depth:

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

Note:

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

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

Form **HB**: order with **No. 123102**.

Form **HE**: order with **No. 123101 + 129100 HE**.

NEW GENERATION AVAILABLE!

Recommended successor products are No. 123025 and 123035.

Standard: Manufacturer's standard

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

Tolerance nominal Ø: h7

recommended maximum drilling depth L_2 : 82.1 mm

Overall length L: 142 mm

Shank Ø D_s : 10 mm

Feed f in steel < 1100 N/mm²: 0.15 mm/rev.

Technical description

Number of cutting edges Z	2
Shank tolerance	h6
Nominal $\varnothing D_c$	8.6 mm
Flute length L_c	95 mm
Feed f in steel < 1100 N/mm ²	0.15 mm/rev.
Tolerance nominal \varnothing	h7
Shank $\varnothing D_s$	10 mm
Overall length L	142 mm
Standard	Manufacturer's standard
recommended maximum drilling depth L_2	82.1 mm
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	8xD
Point angle	135 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

Shank grinding Type HE	129100 HE
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