

## Garant

**Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 8,6 mm**



### Order data

Order number	123102 8,6
GTIN	4045197458636
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:

clamping slot length (see table) less 1.5×nominal Ø.

#### Note:

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

#### **NEW GENERATION AVAILABLE!**

**Recommended successor products are No. 123026 and 123036.**

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/mm<sup>2</sup>: 0.15 mm/rev.

### Technical description

Flute length $L_c$	95 mm
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Number of cutting edges Z	2
Nominal $\varnothing D_c$	8.6 mm
Feed f in steel < 1100 N/mm <sup>2</sup>	0.15 mm/rev.
Shank tolerance	h6
Tolerance nominal $\varnothing$	h7
Shank $\varnothing D_s$	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	8xD
Point angle	135 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