

## Garant

### Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC h7: 7,8 mm



#### Order data

Order number	123110 7,8
GTIN	4045197357601
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!

**Straight major 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. 123115**.

Form **HE**: order with **No. 123110 + 129100 HE**.

Standard: Manufacturer's standard

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

Tolerance nominal Ø: h7

recommended maximum drilling depth  $L_2$ : 79.3 mm

Overall length L: 130 mm

Shank Ø  $D_s$ : 8 mm

Feed f in stainless steel < 900 N/mm<sup>2</sup>: 0.12 mm/rev.

#### Technical description

Flute length $L_c$	91 mm
Number of cutting edges Z	2
Feed f in stainless steel < 900 N/mm <sup>2</sup>	0.12 mm/rev.
Nominal $\varnothing D_c$	7.8 mm
Shank tolerance	h6
Tolerance nominal $\varnothing$	h7
Shank $\varnothing D_s$	8 mm
Overall length L	130 mm
Standard	Manufacturer's standard
recommended maximum drilling depth $L_2$	79.3 mm
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	10xD
Point angle	135 degrees
Cutting direction	right-hand
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
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