

## Garant

### Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC h7: 8,1 mm



#### Order data

Order number	123110 8,1
GTIN	4045197357625
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  $L_2$ : 94.9 mm

Overall length L: 150 mm

Shank Ø  $D_s$ : 10 mm

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

#### Technical description

Nominal $\varnothing D_c$	8.1 mm
Flute length $L_c$	107 mm
Feed $f$ in stainless steel < 900 N/mm <sup>2</sup>	0.15 mm/rev.
Shank tolerance	h6
Number of cutting edges $Z$	2
Tolerance nominal $\varnothing$	h7
Shank $\varnothing D_s$	10 mm
Overall length $L$	150 mm
Standard	Manufacturer's standard
recommended maximum drilling depth $L_2$	94.9 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
------------------------	-----------