

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

Order data

Order number	123110 8,6
GTIN	4045197357663
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 : 94.1 mm

Overall length L: 150 mm

Shank Ø D_s : 10 mm

Feed f in stainless steel < 900 N/mm²: 0.15 mm/rev.

Technical description

Number of cutting edges Z	2
Shank tolerance	h6
Feed f in stainless steel < 900 N/mm ²	0.15 mm/rev.
Nominal Ø D _c	8.6 mm
Flute length L _c	107 mm
Tolerance nominal Ø	h7
Shank Ø D _s	10 mm
Overall length L	150 mm
Standard	Manufacturer's standard
recommended maximum drilling depth L ₂	94.1 mm
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	10×D
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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