

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

Order data

Order number	123115 8,6
GTIN	4045197401939
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 $L_c = L_2 + 1.5 \times D_c$

Machining strategy: HPC

Standard: Manufacturer's standard

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

Semi-Standard: yes

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

Nominal Ø D_c	8.6 mm
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Shank tolerance	h6
Flute length L_c	107 mm
Feed f in stainless steel $< 900 \text{ N/mm}^2$	0.15 mm/rev.
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	94.1 mm
Semi-Standard	yes
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	10xD
Point angle	135 degrees
Shank	DIN 6535 HB to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Colour ring	blue
Type of product	Jobber drill