

Garant

Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC m6 (mm or inch): 8,5 mm or inch



Order data

Order number	123212 8,5
GTIN	4045197570338
Item class	11E

Description

Version:

Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry**. High roundness and alignment accuracy of the deep hole, thanks to **4 guide chamfers**. Outstanding chip evacuation due to **4 internal cooling channels** from Ø 3.8 mm. Up to 3.7 mm Ø with 2 internal cooling channels. **Straight major cutting edges** with honed edges and special flute profile for **short chips**, even on long chipping materials.

Recommendation:

Maximum drilling depth:

flute length (see table) less 1.5×nominal Ø.

Note:

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

For process reliability when using the 12×D drill, an initial centre drilling with NC spotting drills No. 121068– 121130 is necessary.

Form HB and HE are supplied at the same price as HA.

Order form **HB**: with **No. 123214**.

Order form **HE**: with **No. 123212 + 129100HE**.

Standard: Manufacturer's standard

Tolerance nominal Ø: m6

Number of cutting edges Z: 2

Tolerance nominal Ø: m6

recommended maximum drilling depth L_2 : 107.3 mm

Overall length L: 162 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
Feed f in stainless steel > 900 N/mm ²	0.15 mm/rev.
Nominal Ø D _c	8.5 mm
Flute length L _c	120 mm
Shank tolerance	h6
Tolerance nominal Ø	m6
Shank Ø D _s	10 mm
Overall length L	162 mm
Standard	Manufacturer's standard
recommended maximum drilling depth L ₂	107.3 mm
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	12×D
Point angle	135 degrees
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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