

## Garant

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



### Order data

Order number	123214 8,5
GTIN	4045197573162
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:

clamping slot 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 No. 121068 – 121130 is necessary.

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/mm<sup>2</sup>: 0.15 mm/rev.

### Technical description

Shank tolerance	h6
Feed f in stainless steel > 900 N/mm <sup>2</sup>	0.15 mm/rev.

Number of cutting edges Z	2
Flute length $L_c$	120 mm
Nominal $\varnothing D_c$	8.5 mm
Tolerance nominal $\varnothing$	m6
Shank $\varnothing D_s$	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	12xD
Point angle	135 degrees
Cutting direction	right-hand
Shank	DIN 6535 HB to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Semi-Standard	yes
Colour ring	blue
Type of product	Jobber drill