

## Garant

### Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC h7: 8,5 mm



#### Order data

|              |               |
|--------------|---------------|
| Order number | 123301 8,5    |
| GTIN         | 4045197452481 |
| 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!

**Convex 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  $L_c = L_2 + 1.5 \times D_c$ .

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.

Form **HB**: order with **No. 123302**.

Form **HE**: order with **No. 123301 + 129100HE**.

##### **NEW GENERATION AVAILABLE!**

**Recommended successor products are No. 123225 and 123235.**

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  $L_2$ : 107.3 mm

Overall length L: 162 mm

Shank Ø  $D_s$ : 10 mm

Feed f in steel < 1100 N/mm<sup>2</sup>: 0.15 mm/rev.

## Technical description

|   |                         |
|---|-------------------------|
| Feed f in steel < 1100 N/mm <sup>2</sup>          | 0.15 mm/rev.            |
| Nominal Ø D <sub>c</sub>                          | 8.5 mm                  |
| Flute length L <sub>c</sub>                       | 120 mm                  |
| Shank tolerance                                   | h6                      |
| Number of cutting edges Z                         | 2                       |
| Tolerance nominal Ø                               | h7                      |
| Shank Ø D <sub>s</sub>                            | 10 mm                   |
| Overall length L                                  | 162 mm                  |
| Standard  | Manufacturer's standard |
| recommended maximum drilling depth L <sub>2</sub> | 107.3 mm                |
| Semi-Standard                                     | yes                     |
| Coating   | TiAlN                   |
| Tool material                                     | Solid carbide           |
| Drill depth up to                                 | 12xD                    |
| Point angle                                       | 135 degrees             |
| Shank   | DIN 6535 HA to h6       |
| Through-coolant                                   | yes, with 25 bar        |
| Machining strategy                                | HPC                     |
| Colour ring                                       | green                   |
| Type of product                                   | Jobber drill            |

## Services

|                        |           |
|------------------------|-----------|
| Shank grinding Type HE | 129100 HE |
|------------------------|-----------|