

## Garant

**Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 8,5 mm**



### Order data

Order number	123302 8,5
GTIN	4045197459282
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:

clamping slot length (see table) less  $1.5 \times \text{nominal } \varnothing$ .

#### Note:

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

For process reliability when using the  $12 \times D$  deep-hole drill, an initial centre drilling with No. 121068 – 121130 or  $3 \times D$  pilot drilling operation with No. 122736 is necessary.

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

**Recommended successor products are No. 123226 and 123236.**

Standard: Manufacturer's standard

Tolerance nominal  $\varnothing$ : h7

Number of cutting edges Z: 2

Tolerance nominal  $\varnothing$ : h7

recommended maximum drilling depth  $L_2$ : 107.3 mm

Overall length L: 162 mm

Shank  $\varnothing D_s$ : 10 mm

Feed f in steel  $< 1100 \text{ N/mm}^2$ : 0.15 mm/rev.

### Technical description

Number of cutting edges Z	2
Flute length $L_c$	120 mm
Feed f in steel < 1100 N/mm <sup>2</sup>	0.15 mm/rev.
Shank tolerance	h6
Nominal $\varnothing D_c$	8.5 mm
Tolerance nominal $\varnothing$	h7
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	12×D
Point angle	135 degrees
Cutting direction	right-hand
Shank	DIN 6535 HB to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Pilot drill required	yes, pilot drill
Semi-Standard	yes
Colour ring	green
Type of product	Jobber drill