

## Garant

### Solid carbide HPC deep-hole drill plain shank DIN 6535 HA 40×D, TiAlN, Ø DC: 8,5 mm



#### Order data

Order number	123740 8,5
GTIN	4045197498243
Item class	11E

#### Description

##### Version:

Spiral fluted, with **4 guide chamfers** and internal cooling channels. New generation of high performance deep hole drills in the HPC range. **With 135° point angle** and special **fg6 cutting edge tolerance** for optimum generation of deep holes. **High roundness and alignment accuracy of the deep hole.**

##### Recommendation:

##### Maximum drilling depth:

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

##### Note:

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

To achieve good process reliability with 40×D and 50×D deep-hole drills it is absolutely essential to drill 6×D pilot hole with a No. 122736 and a 20×D co-pilot hole with a No. 123691 co-pilot drill.

**The generation of a pilot hole improves process reliability.** See also pages 129/130.

Standard: Manufacturer's standard

Tolerance nominal Ø: fg6

Number of cutting edges Z: 2

Tolerance nominal Ø: fg6

recommended maximum drilling depth  $L_2$ : 367.3 mm

Overall length L: 430 mm

Shank Ø  $D_s$ : 10 mm

Feed f in steel < 900 N/mm<sup>2</sup>: 0.14 mm/rev.

#### Technical description

Number of cutting edges Z	2
Feed f in steel < 900 N/mm <sup>2</sup>	0.14 mm/rev.

Nominal $\varnothing D_c$	8.5 mm
Flute length $L_c$	380 mm
Tolerance nominal $\varnothing$	fg6
Shank $\varnothing D_s$	10 mm
Overall length L	430 mm
Standard	Manufacturer's standard
recommended maximum drilling depth $L_2$	367.3 mm
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	40xD
Point angle	135 degrees
Shank	DIN 6535 HA to h6
Through-coolant	yes, with 40 bar
Machining strategy	HPC
Pilot drill required	yes, pilot and co-pilot drill
Colour ring	green
Type of product	Jobber drill