

**Garant**
**Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC h7: 8,1mm**


## Order data

Order number	122500 8,1
GTIN	4045197050434
Item class	11E

## Description

### Version:

Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry**. **Convex cutting edges** with honed edges and special flute profile for **short chips**, even on long chipping materials.

### Note:

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

**NEW GENERATION AVAILABLE!**

**Recommended successor products are No. 122415; 122425; 122435 and 122361, as well as 122371.**

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

Form **HB**: order with **No. 122445/122505**.

Form **HE**: order with **No. 122440/122500** and **129100HE**.

## Technical description

Flute length $L_c$	47 mm
Shank tolerance	h6
Feed $f$ in steel $< 1100 \text{ N/mm}^2$	0.2 mm/rev.
Number of cutting edges $Z$	2
Nominal $\varnothing D_c$	8.1 mm
Tolerance nominal $\varnothing$	h7
Shank $\varnothing D_s$	10 mm
Overall length $L$	89 mm

Standard	DIN 6537 K
recommended maximum drilling depth L <sub>2</sub>	34.9 mm
Coating	TiAlN
Tool material	Solid carbide
Version	4×D
Point angle	140 degrees
Shank	DIN 6535 HA to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Semi-Standard	yes
Colour ring	green
Type of product	Jobber drill

## User data

	Suitability	V <sub>c</sub>	ISO code
Steel < 500 N/mm <sup>2</sup>	suitable only under restricted conditions	120 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	100 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	85 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	65 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	35 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable only under restricted conditions	30 m/min	M
Ti > 850 N/mm <sup>2</sup>	suitable only under restricted conditions	35 m/min	S
GG(G)	suitable	70 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable		
Air	suitable		

## Services

Shank grinding Type HE

129100 HE