

Garant

Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC m6 (mm or inch): 1/4



Order data

Order number	123008 1/4
GTIN	4062406115852
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.

Note:

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

Form **HB**: order with **No. 123010**.

Form **HE**: order with **No. 123008 + 129100HE**.

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

Standard: Manufacturer's standard

Tolerance nominal Ø: m6

Number of cutting edges Z: 2

recommended maximum drilling depth L_2 : 66.3 mm

Tolerance nominal Ø: m6

Overall length L: 114 mm

Shank Ø D_s : 8 mm

Feed f in stainless steel > 900 N/mm²: 0.12 mm/rev.

Technical description

Overall length L	114 mm
Shank Ø D_s	8 mm
Number of cutting edges Z	2

recommended maximum drilling depth L_2	66.3 mm
Feed f in stainless steel $> 900 \text{ N/mm}^2$	0.12 mm/rev.
Standard	Manufacturer's standard
Inch nominal \varnothing corresponds to	6.35 mm
Tolerance nominal \varnothing	m6
Shank tolerance	h6
Flute length L_c	76 mm
Coating	TiAlN
Tool material	Solid carbide
Version	8xD
Point angle	140 °
Shank	DIN 6535 HA to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Semi-Standard	yes
Colour ring	blue
Type of product	Jobber drill

User data

	Suitability	V_c	ISO code
Steel $< 500 \text{ N/mm}^2$	suitable	90 m/min	P
Steel $< 750 \text{ N/mm}^2$	suitable	75 m/min	P
Steel $< 900 \text{ N/mm}^2$	suitable	70 m/min	P
Steel $< 1100 \text{ N/mm}^2$	suitable	55 m/min	P
Steel $< 1400 \text{ N/mm}^2$	suitable	32 m/min	P
INOX $< 900 \text{ N/mm}^2$	suitable	70 m/min	M
INOX $> 900 \text{ N/mm}^2$	suitable	60 m/min	M
wet maximum	suitable		
wet minimum	suitable		

Services

Shank grinding Type HE

129100 HE