

Garant

Solid carbide HPC drill, plain shank DIN 6535 HA, DLC, Ø DC h7: 8,4mm



Order data

Order number	122808 8,4
GTIN	4045197754189
Item class	11E

Description

Version:

DLC coating sp^2 of the latest generation with **low coefficient of friction** results in **outstanding chip clearance**. For **high-performance milling** of **aluminium materials**. **High roundness** and **alignment accuracy of the deep hole**, thanks to **6 guide chamfers**.

Note:

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

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

Form **HB**: order with **No. 122809**.

Form **HE**: order with **No. 122808 + 129100HE**.

Technical description

Feed f in aluminium short-chipping	0.55 mm/rev.
Flute length L_c	95 mm
Number of cutting edges Z	2
Shank Ø D_s	10 mm
Shank tolerance	h6
Nominal Ø D_c	8.4 mm
Overall length L	142 mm
Tolerance nominal Ø	h7
Standard	Manufacturer's standard
recommended maximum drilling depth L_2	82.4 mm

Coating	DLC
Tool material	solid carbide
Version	8xD
Type	W
Point angle	135 degrees
Shank	DIN 6535 HA to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Semi-Standard	yes
Colour ring	yellow
Type of product	Jobber drill

User data

	Suitability	V _c	ISO code
Alu plastics	suitable	325 m/min	N
Aluminium (short chipping)	suitable	360 m/min	N
Alu > 10% Si	suitable	315 m/min	N
PMMA acrylic	suitable	135 m/min	N
PEEK	suitable	110 m/min	N
PVDF GF20	suitable	80 m/min	N
PA 66 GF30	suitable	70 m/min	N
PEEK GF30	suitable	60 m/min	N
PTFE CF25	suitable	70 m/min	N
Cu	suitable	140 m/min	N
CuZn	suitable	160 m/min	N
GRP	suitable	70 m/min	N
CRP	suitable	70 m/min	N
wet maximum	suitable		

wet minimum
Services

suitable

Shank grinding Type HE

129100 HE