

Garant

Solid carbide HPC drill, plain shank DIN 6535 HA, DLC, Ø DC h7: 8,2mm



Order data

| | |
|--------------|---------------|
| Order number | 122808 8,2 |
| GTIN | 4045197754165 |
| 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

| | |
|--|-------------------------|
| Shank tolerance | h6 |
| Flute length L_c | 95 mm |
| Standard | Manufacturer's standard |
| Feed f in aluminium short-chipping | 0.55 mm/rev. |
| Nominal $\varnothing D_c$ | 8.2 mm |
| Tolerance nominal \varnothing | h7 |
| Number of cutting edges Z | 2 |
| Shank $\varnothing D_s$ | 10 mm |
| Overall length L | 142 mm |
| recommended maximum drilling depth L_2 | 82.7 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