

**Garant**
**Solid carbide HPC drill Weldon shank DIN 6535 HB, DLC, Ø DC h7: 8,9mm**


## Order data

Order number	122307 8,9
GTIN	4045197757036
Item class	11E

## Description

### Version:

**DLC coating sp<sup>2</sup>** 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  $L_c = L_2 + 1.5 \times D_c$ .

## Technical description

Tolerance nominal Ø	h7
Nominal Ø D <sub>c</sub>	8.9 mm
Standard	DIN 6537 K
Shank tolerance	h6
Shank Ø D <sub>s</sub>	10 mm
Number of cutting edges Z	2
Overall length L	89 mm
Flute length L <sub>c</sub>	47 mm
Feed f in aluminium short-chipping	0.55 mm/rev.
recommended maximum drilling depth L <sub>2</sub>	33.7 mm
Coating	DLC
Tool material	solid carbide

Version	4xD
Type	W
Point angle	135 degrees
Shank	DIN 6535 HB 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 <sub>c</sub>	ISO code
Alu plastics	suitable	360 m/min	N
Aluminium (short chipping)	suitable	400 m/min	N
Alu > 10% Si	suitable	350 m/min	N
PMMA acrylic	suitable	150 m/min	N
PEEK	suitable	120 m/min	N
PVDF GF20	suitable	90 m/min	N
PA 66 GF30	suitable	80 m/min	N
PEEK GF30	suitable	70 m/min	N
PTFE CF25	suitable	80 m/min	N
Cu	suitable	160 m/min	N
CuZn	suitable	200 m/min	N
GRP	suitable	80 m/min	N
CRP	suitable	80 m/min	N
wet maximum	suitable		
wet minimum	suitable		

