

**Garant**
**Solid carbide HPC drill, plain shank DIN 6535 HA, DLC, Ø DC h7: 8,5mm**

**Order data**

Order number	122808 8,5
GTIN	4045197754196
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**

Standard	Manufacturer's standard
Tolerance nominal Ø	h7
Overall length L	142 mm
Flute length $L_c$	95 mm
Shank Ø $D_s$	10 mm
Nominal Ø $D_c$	8.5 mm
Number of cutting edges Z	2
Shank tolerance	h6
Feed f in aluminium short-chipping	0.55 mm/rev.
recommended maximum drilling depth $L_2$	82.3 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 <sub>c</sub>	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