

## Garant

### Solid carbide HPC drill Weldon shank DIN 6535 HB, DLC, Ø DC h7: 8,5mm



#### Order data

Order number	123179 8,5
GTIN	4045197760135
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  $L_c = L_2 + 1.5 \times D_c$ .

For process reliability when using the 12xD deep-hole drill, an initial centre drilling with No. 121068 – 121130 is necessary.

#### Technical description

Overall length L	162 mm
Tolerance nominal Ø	h7
Number of cutting edges Z	2
Nominal Ø $D_c$	8.5 mm
Feed f in aluminium short-chipping	0.55 mm/rev.
Shank tolerance	h6
Shank Ø $D_s$	10 mm
Flute length $L_c$	120 mm
Standard	Manufacturer's standard
recommended maximum drilling depth $L_2$	107.3 mm
Coating	DLC

Tool material	solid carbide
Version	12xD
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	250 m/min	N
Aluminium (short chipping)	suitable	280 m/min	N
Alu > 10% Si	suitable	245 m/min	N
PMMA acrylic	suitable	105 m/min	N
PEEK	suitable	85 m/min	N
PVDF GF20	suitable	60 m/min	N
PA 66 GF30	suitable	55 m/min	N
PEEK GF30	suitable	50 m/min	N
PTFE CF25	suitable	55 m/min	N
Cu	suitable	120 m/min	N
CuZn	suitable	150 m/min	N
GRP	suitable	55 m/min	N
CRP	suitable	55 m/min	N
wet maximum	suitable		
wet minimum	suitable		

