

**Garant**
**Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 8,5mm**

**Order data**

Order number	123115 8,5
GTIN	4045197401922
Item class	11E

**Description**
**Version:**

Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry**.

Particularly high alignment accuracy due to **4 guide chamfers** which stabilise the drill even at extreme depths!

**Straight major cutting edges** with honed edges and special flute profile for **short chips**, even on long chipping materials.

**Advantage:**

**High process reliability and surface quality of the hole.**

**Note:**

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

**Technical description**

Shank tolerance	h6
Flute length $L_c$	107 mm
Number of cutting edges Z	2
Feed f in stainless steel < 900 N/mm <sup>2</sup>	0.15 mm/rev.
Nominal Ø $D_c$	8.5 mm
Tolerance nominal Ø	h7
Shank Ø $D_s$	10 mm
Overall length L	150 mm
Standard	Manufacturer's standard

recommended maximum drilling depth $L_2$	94.3 mm
Coating	TiAlN
Tool material	Solid carbide
Version	10xD
Point angle	135 degrees
Shank	DIN 6535 HB to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Semi-Standard	yes
Colour ring	blue
Type of product	Jobber drill

## User data

	Suitability	$V_c$	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	200 m/min	N
Alu > 10% Si	suitable only under restricted conditions	180 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	110 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	80 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	70 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	65 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	55 m/min	M
Ti > 850 N/mm <sup>2</sup>	suitable	25 m/min	S
Uni	suitable only under restricted conditions		
wet maximum	suitable		
wet minimum	suitable		

