

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

**Order data**

|              |               |
|--------------|---------------|
| Order number | 123115 8      |
| GTIN         | 4045197401885 |
| 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**

|   |                         |
|---|-------------------------|
| Nominal Ø $D_c$                                   | 8 mm                    |
| Number of cutting edges Z                         | 2                       |
| Flute length $L_c$                                | 91 mm                   |
| Shank tolerance                                   | h6                      |
| Feed f in stainless steel < 900 N/mm <sup>2</sup> | 0.12 mm/rev.            |
| Tolerance nominal Ø                               | h7                      |
| Shank Ø $D_s$                                     | 8 mm                    |
| Overall length L                                  | 130 mm                  |
| Standard  | Manufacturer's standard |

|  |                   |
|--|-------------------|
| recommended maximum drilling depth $L_2$ | 79 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                                  |           |          |

