

Garant

Solid carbide drill plain shank DIN 6535 HA 180°, TiAlN, Ø DC m7: 8,01-Xmm



Order data

Order number	122506 8,01-X
GTIN	4062406200817
Item class	11E

Description

Version:

Special point geometry for generating **180° flat-bottomed holes**. Low radial forces even when spot drilling on faces with up to 45° slope. Flute geometry for optimum chip evacuation. With 4 guide chamfers to stabilise the drill in the hole.

Advantage:

The 180° point angle permits drilling and counterboring in a single operation.

Recommendation:

When using the solid carbide 180° drill it is absolutely essential for process reliability:

- **when spot drilling on flat surfaces to drill a pilot hole 1xD using pilot drill No. 122736.**
- **when spot drilling on sloping surfaces up to 15°: reduce the feed rate f to 50 %, up to 30°: reduce the feed rate f to 40 % and up to 45°: reduce the feed rate f to 25 % of the stated value. After spot drilling, the normal feed rate value can be used.**

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. 122506 + 129100HB**.

Form **HE**: order with **No. 122506 + 129100HE**.

180° solid carbide drills for machining aluminium available on request.

Not suitable for generating counterbores for socket-head screws to DIN974-1. Delivery time: 8 weeks

Minimum order quantity: 3 pcs.

Items made to order for a specific customer: Cancellation only up to a maximum of 3 working days after receipt of order acknowledgement. Items cannot be returned. We reserve the right to over or under deliver by +/-10% (min. 1 pc).

Technical description

Ø range	8.01 - 10 mm
Tolerance nominal Ø	h7
Number of cutting edges Z	2
Overall length L	89 mm
Shank Ø D _s	10 mm
Flute length L _c	47 mm
Standard	Manufacturer's standard
Coating	TiAlN
Tool material	Solid carbide
Version	3xD
Point angle	180 degrees
Shank	DIN 6535 HA to h6
Use for drilling	limited convexity
Use for drilling	limited cross-drilling
Use for drilling	limited oblique spot drilling
Through-coolant	yes, with 25 bar
Pilot drill required	yes, pilot drill
Semi-Standard	yes
Colour ring	green
Type of product	Jobber drill

User data

	Suitability	V _c	ISO code
Steel < 500 N/mm ²	suitable	85 m/min	P
Steel < 750 N/mm ²	suitable	75 m/min	P
Steel < 900 N/mm ²	suitable	60 m/min	P
Steel < 1100 N/mm ²	suitable	50 m/min	P
INOX < 900 N/mm ²	suitable only under restricted conditions	45 m/min	M

GG(G)	suitable	90 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable		
Air	suitable		