

## Garant

**Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, Ø DC m6 (mm or inch): 8,5**



### Order data

|              |               |
|--------------|---------------|
| Order number | 123214 8,5    |
| GTIN         | 4045197573162 |
| Item class   | 11E           |

### Description

#### Version:

Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry**. High roundness and alignment accuracy of the deep hole, thanks to **4 guide chamfers**. Outstanding chip evacuation due to **4 internal cooling channels** from Ø 3.8 mm. Up to 3.7 mm Ø with 2 internal cooling channels. **Straight major cutting edges** with honed edges and special flute profile for **short chips**, even on long chipping materials.

#### Note:

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

For process reliability when using the 12×D drill, an initial centre drilling with No. 121068 – 121130 is necessary.

Standard: Manufacturer's standard

Tolerance nominal Ø: m6

Number of cutting edges Z: 2

recommended maximum drilling depth  $L_2$ : 107.3 mm

Tolerance nominal Ø: m6

Overall length L: 162 mm

Shank Ø  $D_s$ : 10 mm

Feed f in stainless steel > 900 N/mm<sup>2</sup>: 0.15 mm/rev.

### Technical description

|   |              |
|---|--------------|
| Shank tolerance                                   | h6           |
| Feed f in stainless steel > 900 N/mm <sup>2</sup> | 0.15 mm/rev. |
| Number of cutting edges Z                         | 2            |
| Flute length $L_c$                                | 120 mm       |

|  |                         |
|--|-------------------------|
| Nominal $\varnothing D_c$                | 8.5 mm                  |
| Tolerance nominal $\varnothing$          | m6                      |
| Shank $\varnothing D_s$                  | 10 mm                   |
| Overall length L                         | 162 mm                  |
| Standard                                 | Manufacturer's standard |
| recommended maximum drilling depth $L_2$ | 107.3 mm                |
| Coating                                  | TiAlN                   |
| Tool material                            | Solid carbide           |
| Version                                  | 12xD                    |
| Point angle                              | 135 °                   |
| 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 |
|--------------------------------|-------------|----------|----------|
| Steel < 500 N/mm <sup>2</sup>  | suitable    | 90 m/min | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable    | 75 m/min | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable    | 70 m/min | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable    | 55 m/min | P        |
| Steel < 1400 N/mm <sup>2</sup> | suitable    | 32 m/min | P        |
| INOX < 900 N/mm <sup>2</sup>   | suitable    | 70 m/min | M        |
| INOX > 900 N/mm <sup>2</sup>   | suitable    | 60 m/min | M        |
| Uni                            | suitable    |          |          |
| wet maximum                    | suitable    |          |          |
| wet minimum                    | suitable    |          |          |

