

## Garant

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



#### Order data

Order number	122675 8,5
GTIN	4045197398192
Item class	11E

#### Description

##### Version:

**Particularly strong** due to strengthened core and **special profile**. Special point geometry.

**High concentricity** and **long tool life**.

**Precision drilling qualities**.

##### Recommendation:

##### Maximum drilling depth:

Flute length (see table) less 1.5×nominal Ø.

##### Note:

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

Standard: DIN 6537

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

Tolerance nominal Ø: h7

recommended maximum drilling depth  $L_2$ : 48.3 mm

Overall length L: 103 mm

Shank Ø  $D_s$ : 10 mm

Feed f in titanium > 850 N/mm<sup>2</sup>: 0.12 mm/rev.

#### Technical description

Feed f in titanium > 850 N/mm <sup>2</sup>	0.12 mm/rev.
Number of cutting edges Z	2
Flute length $L_c$	61 mm
Nominal Ø $D_c$	8.5 mm

Shank tolerance	h6
Tolerance nominal $\varnothing$	h7
Shank $\varnothing D_s$	10 mm
Overall length L	103 mm
Standard	DIN 6537
recommended maximum drilling depth $L_2$	48.3 mm
Coating	TiAlN
Tool material	Solid carbide
	6×D
Type	FS
Point angle	140°
Shank	DIN 6535 HB to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Semi-Standard	yes
Colour ring	pink
Type of product	Jobber drill

## User data

	Suitability	$V_c$	ISO code
Alu plastics	suitable	260 m/min	N
Aluminium (short chipping)	suitable	240 m/min	N
Alu > 10% Si	suitable	160 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	110 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	90 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	85 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	60 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable only under restricted conditions	30 m/min	P

INOX < 900 N/mm <sup>2</sup>	suitable	40 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	35 m/min	M
Ti > 850 N/mm <sup>2</sup>	suitable	35 m/min	S
wet maximum	suitable		
wet minimum	suitable		
Air	suitable		