Garant

Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, ∅ h7: 8,2 mm

Order data

Order number	123302 8,2
GTIN	4045197459275
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!
Convex 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.
Recommendation:
Maximum drilling depth:
clamping slot length (see table) less 1.5×nominal ∅.
Note:
For process reliability when using the 12×D deep-hole drill, an initial centre drilling with No. 121068– 121130 or 3×D pilot drilling operation with No. 122736 is necessary.
NEW GENERATION AVAILABLE!
Recommended successor products are No. 123226 and 123236.
Norm: Manufacturer's standard
Tolerance nominal ∅: h7
Number of cutting edges Z: 2
Tolerance nominal ∅: h7
Flute length: 120 mm
Overall length L_{tot}: 162 mm
Shank ∅: 10 mm
Feed f in steel < 1100 N/mm^2: 0.15 mm/rev.

Technical description

Feed f in steel < 1100 N/mm^2	0.15 mm/rev.
Number of cutting edges Z	2
Flute length	120 mm
Nominal ∅	8.2 mm
Shank tolerance	h6
Tolerance nominal ∅	h7
Shank ∅	10 mm
Overall length L_{tot}	162 mm
Norm	Manufacturer's standard
recommended maximum drilling depth	107.7 mm
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	12×D
Point angle	135 degrees
Skaft	DIN 6535 HB to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Pilot drill required	yes, pilot drill
Colour ring	green