

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

**Order data**

Order number	122505 8
GTIN	4045197391858
Item class	11E

**Description**
**Version:**

Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry. Convex cutting edges** with honed edges and special flute profile for **short chips**, even on long chipping materials.

**Note:**

**NEW GENERATION AVAILABLE!**

**Recommended successor products are No. 122426 and 122436.**

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

**Technical description**

Nominal Ø $D_c$	8 mm
Shank tolerance	h6
Flute length $L_c$	41 mm
Feed $f$ in steel < 1100 N/mm <sup>2</sup>	0.2 mm/rev.
Number of cutting edges $Z$	2
Tolerance nominal Ø	h7
Shank Ø $D_s$	8 mm
Overall length $L$	79 mm
Standard	DIN 6537 K
recommended maximum drilling depth $L_2$	29 mm
Coating	TiAlN

Tool material	Solid carbide
Version	4xD
Point angle	140 degrees
Shank	DIN 6535 HB to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Colour ring	green
Type of product	Jobber drill

### User data

	Suitability	V <sub>c</sub>	ISO code
Steel < 500 N/mm <sup>2</sup>	suitable only under restricted conditions	120 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	100 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	85 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	65 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	35 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable only under restricted conditions	30 m/min	M
Ti > 850 N/mm <sup>2</sup>	suitable only under restricted conditions	35 m/min	S
GG(G)	suitable	70 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable		
Air	suitable		