

**Garant**
**Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 8,6mm**


## Order data

Order number	122765 8,6
GTIN	4045197399069
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:

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

**NEW GENERATION AVAILABLE!**

**Recommended successor products are No. 122716 and 122726.**

## Technical description

Feed f in steel < 1100 N/mm <sup>2</sup>	0.2 mm/rev.
Nominal Ø D <sub>C</sub>	8.6 mm
Shank tolerance	h6
Flute length L <sub>c</sub>	61 mm
Number of cutting edges Z	2
Tolerance nominal Ø	h7
Shank Ø D <sub>s</sub>	10 mm
Overall length L	103 mm
Standard	DIN 6537
recommended maximum drilling depth L <sub>2</sub>	48.1 mm

Coating	TiAlN
Tool material	Solid carbide
Version	6×D
Point angle	140 degrees
Shank	DIN 6535 HB to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Semi-Standard	yes
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
Steel < 55 HRC	suitable	28 m/min	H
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		
Air	suitable		

