

## Garant

**Solid carbide drill IC plain shank unidirectional DIN 6535 HA, Diamond, Ø DC m7: 8,5 mm**



### Order data

Order number	122532 8,5
GTIN	4062406349196
Item class	11Y

### Description

#### Version:

With the latest generation of **crystalline diamond coating sp<sup>3</sup>**, for process reliability in machining **fibre-reinforced composites, CRP, GRP, and graphite. With 90° point angle** and special geometry to **avoid delamination.**

Under optimum conditions of use, the **double flute face** can generate high precision holes (**roundness < 15 µm to base tolerance IT 7**). Low heat generation due to **internal cooling** permits **higher speeds and feeds.**

#### Recommendation:

##### Maximum drilling depth:

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

##### Note:

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

Available in **1/100 sizes** and according to the table.

Tolerance nominal Ø: m7

Number of cutting edges Z: 2

Ø range (1/100 size): 8.01 - 8.99 mm

recommended maximum drilling depth  $L_2$ : 48.25 mm

Overall length L: 103 mm

Shank Ø  $D_s$ : 10 mm

Feed f in GRP CRP: 0.15 mm/rev.

### Technical description

Number of cutting edges Z	2
recommended maximum drilling depth $L_2$	48.25 mm

Ø range (1/100 size)	8.01 - 8.99 mm
Feed f in GRP CRP	0.15 mm/rev.
Flute length L <sub>c</sub>	61 mm
Overall length L	103 mm
Tolerance nominal Ø	m7
Nominal Ø D <sub>c</sub>	8.5 mm
Shank tolerance	h6
Shank Ø D <sub>s</sub>	10 mm
Coating	Diamond
Tool material	Solid carbide
Standard	Manufacturer's standard
Drill depth up to	5×D
Point angle	90 degrees
Cutting direction	right-hand
Shank	DIN 6535 HA to h6
Through-coolant	yes, with 25 bar
Colour ring	black
Type of product	Jobber drill