

## Garant

**Solid carbide NC high performance drill FS, plain shank DIN 6535 HA, TiAlN, Ø DC h7: 8,6mm**



### Order data

Order number	122540 8,6
GTIN	4045197052230
Item class	11E

### Description

#### Version:

**Particularly strong** due to strengthened core and **special profile**. Special point geometry. **High concentricity** and **long tool life**. **High bore quality**.

#### Note:

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

Form HB and HE supplied at the same price as HA.

Form **HB**: order with **No. 122545**.

Form **HE**: order with **No. 122540 + 129100HE**.

### Technical description

Nominal Ø $D_c$	8.6 mm
Shank tolerance	h6
Number of cutting edges Z	2
Flute length $L_c$	61 mm
Feed f in steel < 750 N/mm <sup>2</sup>	0.2 mm/rev.
Tolerance nominal Ø	h7
Shank Ø $D_s$	10 mm
Overall length L	103 mm
Standard	DIN 6537
recommended maximum drilling depth $L_2$	48.1 mm

Coating	TiAlN
Tool material	Solid carbide
Version	6×D
Type	FS
Point angle	140 degrees
Shank	DIN 6535 HA to h6
Through-coolant	no
Semi-Standard	yes
Colour ring	green
Type of product	Jobber drill

## User data

	Suitability	V <sub>c</sub>	ISO code
Alu plastics	suitable	190 m/min	N
Aluminium (short chipping)	suitable	170 m/min	N
Alu > 10% Si	suitable	140 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	90 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	85 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	75 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	65 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	40 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable only under restricted conditions	40 m/min	M
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	25 m/min	S
GG(G)	suitable only under restricted conditions	70 m/min	K

CuZn	suitable only under restricted conditions	160 m/min	N
Uni	suitable		
wet maximum	suitable		
<del>dry</del>	<del>suitable</del>		
<b>Services</b>			
Shank grinding Type HE		129100 HE	