

Garant

Solid carbide NC high performance drill FS, plain shank DIN 6535 HA, TiAlN, Ø DC h7: 8,4mm



Order data

Order number	122540 8,4
GTIN	4045197052216
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

Flute length L_c	61 mm
Number of cutting edges Z	2
Feed f in steel $< 750 \text{ N/mm}^2$	0.2 mm/rev.
Nominal $\varnothing D_c$	8.4 mm
Shank tolerance	h6
Tolerance nominal \varnothing	h7
Shank $\varnothing D_s$	10 mm
Overall length L	103 mm
Standard	DIN 6537
recommended maximum drilling depth L_2	48.4 mm

Coating	TiAlN
Tool material	Solid carbide
Version	6xD
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 _c	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 ²	suitable	90 m/min	P
Steel < 750 N/mm ²	suitable	85 m/min	P
Steel < 900 N/mm ²	suitable	75 m/min	P
Steel < 1100 N/mm ²	suitable	65 m/min	P
Steel < 1400 N/mm ²	suitable	40 m/min	P
INOX < 900 N/mm ²	suitable only under restricted conditions	40 m/min	M
INOX > 900 N/mm ²	suitable only under restricted conditions	30 m/min	M
Ti > 850 N/mm ²	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		
dry	suitable		
Services			
Shank grinding Type HE		129100 HE	