

Garant

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



Order data

Order number	122545 8,4
GTIN	4045197393371
Item class	11E

Description

Version:

Particularly strong due to strengthened core and **special profile**. Special point geometry. **High concentricity** and **long tool life**. **Precision drilling qualities**.

Note:

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

Technical description

Nominal $\varnothing D_c$	8.4 mm
Feed f in steel < 750 N/mm ²	0.2 mm/rev.
Shank tolerance	h6
Flute length L_c	61 mm
Number of cutting edges Z	2
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 HB 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