

**Garant**
**Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, Ø DC m6: 8,5mm**

**Order data**

Order number	123010 8,5
GTIN	4045197572493
Item class	11E

**Description**
**Version:**

Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry**. High roundness and alignment accuracy of the deep hole, thanks to **4 guide chamfers**. Outstanding chip evacuation due to **4 internal cooling channels** from Ø 3.8 mm. Up to 3.7 mm Ø with 2 internal cooling channels. **Straight major cutting edges** with honed edges and special flute profile for **short chips**, even on long chipping materials.

**Note:**

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

**Technical description**

Number of cutting edges Z	2
Shank tolerance	h6
Feed f in stainless steel > 900 N/mm <sup>2</sup>	0.15 mm/rev.
Nominal Ø D <sub>c</sub>	8.5 mm
Flute length L <sub>c</sub>	95 mm
Tolerance nominal Ø	m6
Shank Ø D <sub>s</sub>	10 mm
Overall length L	142 mm
Standard	Manufacturer's standard
recommended maximum drilling depth L <sub>2</sub>	82.3 mm
Coating	TiAlN

Tool material	Solid carbide
Version	8×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	blue
Type of product	Jobber drill

### User data

	Suitability	V <sub>c</sub>	ISO code
Steel < 500 N/mm <sup>2</sup>	suitable	90 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	75 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	70 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	55 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	32 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	70 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	60 m/min	M
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable		