Garant

Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, ⌀ DC h7: 8,1mm

Order data

Order number	123101 8,1
GTIN	4045197451798
Item class	11E

Description

Version:
Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry.**
Particularly high alignment accuracy due to **4 guide chamfers** which stabilise the drill even at extreme depths!
Convex cutting edges with honed edges and special flute profile for **short chips**, even on long chipping materials.
Advantage:
High process reliability and surface quality of the hole.
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. 123102**.
Form **HE:** order with **No. 123101 + 129100 HE**.
NEW GENERATION AVAILABLE!
Recommended successor products are No. 123025 and 123035.

Technical description

Nominal ⌀ D_C	8.1 mm
Shank tolerance	h6
Number of cutting edges Z	2
Flute length L_c	95 mm
Feed f in steel < 1100 N/mm^2	0.15 mm/rev.
Tolerance nominal ⌀	h7

Shank ∅ D_s	10 mm
Overall length L	142 mm
Standard	Manufacturer's standard
recommended maximum drilling depth L_2	82.9 mm
Coating	TiAlN
Tool material	Solid carbide
Version	8×D
Point angle	135 degrees
Shank	DIN 6535 HA to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Semi-Standard	yes
Colour ring	green
Type of product	Jobber drill

User data

	Suitability	V_c	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	180 m/min	N
Alu > 10% Si	suitable only under restricted conditions	140 m/min	N
Steel < 500 N/mm²	suitable only under restricted conditions	110 m/min	P
Steel < 750 N/mm²	suitable	90 m/min	P
Steel < 900 N/mm²	suitable	80 m/min	P
Steel < 1100 N/mm²	suitable	50 m/min	P
Steel < 1400 N/mm²	suitable	35 m/min	P
INOX < 900 N/mm²	suitable only under restricted conditions	40 m/min	M

INOX > 900 N/mm²	suitable only under restricted conditions	35 m/min	M
GG(G)	suitable	70 m/min	K
Uni	suitable		
wet maximum	suitable		

Services

Shank grinding Type HE	129100 HE