

**Garant**
**Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 8,6mm**

**Order data**

Order number	122445 8,6
GTIN	4045197390257
Item class	11E

**Description**
**Version:**

Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry**. **Convex cutting edges** with honed edges and special flute profile for **short chips**, even on long chipping materials.

**Note:**

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

**NEW GENERATION AVAILABLE!**

**Recommended successor product is No. 122416.**

**Technical description**

Nominal Ø $D_c$	8.6 mm
Feed $f$ in steel $< 1100 \text{ N/mm}^2$	0.2 mm/rev.
Number of cutting edges $Z$	2
Flute length $L_c$	47 mm
Shank tolerance	h6
Tolerance nominal Ø	h7
Shank Ø $D_s$	10 mm
Overall length $L$	89 mm
Standard	DIN 6537 K
recommended maximum drilling depth $L_2$	34.1 mm
Coating	TiAlN

Tool material	Solid carbide
Version	4×D
Point angle	140 degrees
Shank	DIN 6535 HB to h6
Through-coolant	no
Machining strategy	HPC
Colour ring	green
Type of product	Jobber drill

### User data

	Suitability	V <sub>c</sub>	ISO code
Steel < 500 N/mm <sup>2</sup>	suitable only under restricted conditions	90 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	80 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	70 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	65 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	35 m/min	P
Ti > 850 N/mm <sup>2</sup>	suitable only under restricted conditions	35 m/min	S
GG(G)	suitable	70 m/min	K
Uni	suitable		
wet maximum	suitable		
dry	suitable		