

Garant
Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 8,5mm

Order data

Order number	123102 8,5
GTIN	4045197458629
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 $L_c = L_2 + 1.5 \times D_c$.

NEW GENERATION AVAILABLE!

Recommended successor products are No. 123026 and 123036.

Technical description

Feed f in steel < 1100 N/mm ²	0.15 mm/rev.
Flute length L _c	95 mm
Number of cutting edges Z	2
Nominal Ø D _c	8.5 mm
Shank tolerance	h6
Tolerance nominal Ø	h7
Shank Ø D _s	10 mm
Overall length L	142 mm

Standard	Manufacturer's standard
recommended maximum drilling depth L ₂	82.3 mm
Coating	TiAlN
Tool material	Solid carbide
Version	8×D
Point angle	135 degrees
Shank	DIN 6535 HB 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/mm ²	suitable only under restricted conditions	110 m/min	P
Steel < 750 N/mm ²	suitable	90 m/min	P
Steel < 900 N/mm ²	suitable	80 m/min	P
Steel < 1100 N/mm ²	suitable	50 m/min	P
Steel < 1400 N/mm ²	suitable	35 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	35 m/min	M
GG(G)	suitable	70 m/min	K

Uni	suitable
wet maximum	suitable