Garant

Solid carbide HPC co-pilot drill, plain shank DIN 6535 HA 20×D, TiAlN, ⌀ DC: 8,5mm

Order data

Order number	123691 8,5
GTIN	4045197569257
Item class	11E

Description

Version:
Helical fluted, with **4 guide chamfers** and internal coolant holes. New generation of high performance co-pilot drills in the HPC range. **With 138° point angle** and special **j6 cutting edge tolerance** for optimum generation of a co-pilot hole. **High roundness and alignment accuracy of the co-pilot hole.**
Note:
Flute length $L_C = L_2 + 1.5 \times D_C$.
To achieve good process reliability with 40×D and 50×D deep hole drills, it is absolutely essential to drill a pilot hole to the maximum drilling depth with a pilot drill No. 122736 and a 20×D co-pilot hole with a co-pilot drill No. 123691.
The generation of a pilot hole improves process reliability. See also pages 140/141.

Technical description

Nominal ⌀ D_C	8.5 mm
Flute length L_c	195 mm
Number of cutting edges Z	2
Feed f in steel < 900 N/mm^2	0.14 mm/rev.
Tolerance nominal ⌀	j6
Shank ⌀ D_s	10 mm
Overall length L	260 mm
Standard	Manufacturer's standard

recommended maximum drilling depth L_2	182.3 mm
Coating	TiAlN
Tool material	Solid carbide
Version	20×D
Point angle	138 degrees
Shank	DIN 6535 HA to h6
Through-coolant	yes, with 40 bar
Machining strategy	HPC
Pilot drill required	yes, pilot drill
Colour ring	green
Type of product	Jobber drill

User data

	Suitability	V_c	ISO code
Steel < 500 N/mm²	suitable	105 m/min	P
Steel < 750 N/mm²	suitable	90 m/min	P
Steel < 900 N/mm²	suitable	90 m/min	P
Steel < 1100 N/mm²	suitable	90 m/min	P
Steel < 1400 N/mm²	suitable	70 m/min	P
INOX < 900 N/mm²	suitable	50 m/min	M
INOX > 900 N/mm²	suitable only under restricted conditions	45 m/min	M
GG(G)	suitable	95 m/min	K
Uni	suitable		
wet maximum	suitable		