

**Garant**
**Solid carbide HPC deep hole drill plain shank DIN 6535 HA 40×D, TiAlN, Ø DC: 8,5mm**

**Order data**

Order number	123740 8,5
GTIN	4045197498243
Item class	11E

**Description**
**Version:**

Spiral fluted, with **4 guide chamfers** and internal cooling channels. New generation of high performance deep hole drills in the HPC range. **With 135° point angle** and special **fg6 cutting edge tolerance** for optimum generation of deep holes. **High roundness and alignment accuracy of the deep 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**

Number of cutting edges Z	2
Feed f in steel < 900 N/mm <sup>2</sup>	0.14 mm/rev.
Nominal Ø D <sub>c</sub>	8.5 mm
Flute length L <sub>c</sub>	380 mm
Tolerance nominal Ø	fg6
Shank Ø D <sub>s</sub>	10 mm
Overall length L	430 mm
Standard	Manufacturer's standard

recommended maximum drilling depth $L_2$	367.3 mm
Coating	TiAlN
Tool material	Solid carbide
Version	40xD
Point angle	135 degrees
Shank	DIN 6535 HA to h6
Through-coolant	yes, with 40 bar
Machining strategy	HPC
Pilot drill required	yes, pilot and co-pilot drill
Colour ring	green
Type of product	Jobber drill

## User data

	Suitability	$V_c$	ISO code
Steel < 500 N/mm <sup>2</sup>	suitable	75 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	60 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	60 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	60 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	50 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	40 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable only under restricted conditions	35 m/min	M
GG(G)	suitable	65 m/min	K
Uni	suitable		
wet maximum	suitable		