

Garant

Solid carbide HPC drill, plain shank DIN 6535 HA, TiAlSiN, Ø DC m7: 8,5mm



Order data

Order number	122680 8,5
GTIN	4062406779948
Item class	11E

Description

Version:

Specially for machining **titanium-based and nickel-based alloys**. With wear-resistant, ultra-smooth TiAlSiN high-performance coating for a **long tool life** combined with **optimum bore quality** and **very low burr formation**.

Note:

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

HB and HE shanks are available at the same price as HA.

For **HB**: use order **No. 122681**.

For **HE**: use order **No. 122680** and **129100HE**.

Technical description

Number of cutting edges Z	2
Standard	DIN 6537
Overall length L	103 mm
Nominal Ø D_c	8.5 mm
Shank Ø D_s	10 mm
Tolerance nominal Ø	m7
Feed f in titanium > 850 N/mm ²	0.11 mm/rev.
recommended maximum drilling depth L_2	48.3 mm
Flute length L_c	61.05 mm
Coating	TiAlSiN

Tool material	Solid carbide
Version	6×D
Point angle	140 degrees
Shank	DIN 6535 HA to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Semi-Standard	yes
Colour ring	pink
Type of product	Jobber drill

User data

	Suitability	V _c	ISO code
Ti > 850 N/mm ²	suitable		
Inconel	suitable		
wet maximum	suitable		

Services

Shank grinding Type HE	129100 HE
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