

**Garant**
**Solid carbide HPC drill, plain shank DIN 6535 HA, TiAlSiN, Ø DC m7: 8,6mm**

**Order data**

Order number	122480 8,6
GTIN	4062406779085
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. 122481**.

For **HE**: use order **No. 122480** and **129100HE**.

**Technical description**

Nominal Ø $D_c$	8.6 mm
Number of cutting edges Z	2
Shank Ø $D_s$	10 mm
recommended maximum drilling depth $L_2$	34.1 mm
Standard	DIN 6537 K
Overall length L	89 mm
Tolerance nominal Ø	m7
Flute length $L_c$	47 mm
Feed f in titanium > 850 N/mm <sup>2</sup>	0.11 mm/rev.
Coating	TiAlSiN

Tool material	Solid carbide
Version	4xD
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 <sub>c</sub>	ISO code
Ti > 850 N/mm <sup>2</sup>	suitable		
Inconel	suitable		
wet maximum	suitable		

### Services

Shank grinding Type HE	129100 HE
------------------------	-----------