

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

**Order data**

|              |               |
|--------------|---------------|
| Order number | 122480 8,8    |
| GTIN         | 4062406779108 |
| 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**

|   |              |
|---|--------------|
| Overall length L                                  | 89 mm        |
| Feed f in titanium > 850 N/mm <sup>2</sup>        | 0.11 mm/rev. |
| Flute length L <sub>c</sub>                       | 47 mm        |
| recommended maximum drilling depth L <sub>2</sub> | 33.8 mm      |
| Tolerance nominal Ø                               | m7           |
| Standard  | DIN 6537 K   |
| Shank Ø D <sub>s</sub>                            | 10 mm        |
| Number of cutting edges Z                         | 2            |
| Nominal Ø D <sub>c</sub>                          | 8.8 mm       |
| 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 |
|------------------------|-----------|