

Garant
Solid carbide drill for aramide, uncoated, Ø DC h6: 8,5mm

Order data

Order number	121230 8,5
GTIN	4045197472052
Item class	11Y

Description
Version:

Special geometry for reliable drilling of aramide plastics (polyaramides) and aramide fibres as well as thermoplastics and thermosetting plastics.

Note:

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

Technical description

Flute length L_c	37 mm
Nominal $\varnothing D_c$	8.5 mm
Shank tolerance	h6
Feed f in AFK	0.09 mm/rev.
Number of cutting edges Z	2
Tolerance nominal \varnothing	h6
Shank $\varnothing D_s$	8.5 mm
Overall length L	79 mm
Standard	Manufacturer's standard
recommended maximum drilling depth L_2	24.3 mm
Coating	uncoated
Tool material	Solid carbide
Version	4xD

Shank	Parallel shank to h6
Use for drilling	for aramides
Through-coolant	no
Colour ring	without
Type of product	Jobber drill

User data

	Suitability	V _c	ISO code
PE-HD	suitable only under restricted conditions	140 m/min	N
PA 66	suitable only under restricted conditions	130 m/min	N
PEEK	suitable only under restricted conditions	120 m/min	N
PF 31	suitable only under restricted conditions	100 m/min	N
AFRP aramid	suitable	110 m/min	N
Honeycomb sandwich	suitable only under restricted conditions	120 m/min	N
dry	suitable		
Air	suitable		