

**Garant**

**Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC m6 (mm or inch): 8,06-X**


**Order data**

Order number	123008 8,06-X
GTIN	4062406079802
Item class	11E

**Description**
**IMPORTANT: item is configurable**

Ø range: 8.06 - 10.05 mm, Intervall: 0,010

**Version:**

Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry**. High roundness and alignment accuracy of the deep hole, thanks to **4 guide chamfers**. Outstanding chip evacuation due to **4 internal cooling channels** from Ø 3.8 mm. Up to 3.7 mm Ø with 2 internal cooling channels. **Straight major cutting edges** with honed edges and special flute profile for **short chips**, even on long chipping materials.

**Note:**

Form HB and HE supplied at the same price as HA.

Form **HB**: order with **No. 123010**.

Form **HE**: order with **No. 123008 + 129100HE**.

Flute length  $L_c = L_2 + 1.5 \times D_c$ . Delivery time: 12 working weeks

Minimum order quantity: 3 pcs

Items made to order for a specific customer:

Cancellation only up to a maximum of 3 working days after receipt of order acknowledgement.

Items cannot be returned. We reserve the right to over-deliver or under-deliver by  $\pm 10\%$  (minimum 1 piece).

Standard: Manufacturer's standard

Tolerance nominal Ø: m6

Number of cutting edges Z: 2

Tolerance nominal Ø: m6

Overall length L: 142 mm

Shank Ø  $D_s$ : 10 mm

Feed f in stainless steel  $> 900 \text{ N/mm}^2$ : 0.12 mm/rev.

**Technical description**

Shank Ø D <sub>s</sub>	10 mm
Standard	Manufacturer's standard
Feed f in stainless steel > 900 N/mm <sup>2</sup>	0.12 mm/rev.
Tolerance nominal Ø	m6
Number of cutting edges Z	2
Overall length L	142 mm
Flute length L <sub>c</sub>	95 mm
Ø range	8.06 - 10.05 mm
Coating	TiAlN
Tool material	Solid carbide
Version	8×D
Point angle	140 °
Shank	DIN 6535 HA to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Semi-Standard	yes
Colour ring	blue
Type of product	Jobber drill

## User data

	Suitability	V <sub>c</sub>	ISO code
Steel < 500 N/mm <sup>2</sup>	suitable	90 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	75 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	70 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	55 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	32 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	70 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	60 m/min	M

wet maximum

suitable

wet minimum

suitable