

Garant
Solid carbide drill plain shank for multi-directional fibre orientation DIN 6535 HA, Diamond, Ø DC m7: 8,5mm

Order data

Order number	122512 8,5
GTIN	4062406349059
Item class	11Y

Description
Version:

With the latest generation of **crystalline diamond coating sp^3** , for process reliability in machining **fibre-reinforced composites, CRP, GRP, and graphite. With 90° point angle** and special geometry to **avoid delamination**.

With guide chamfer for materials with **multi-directional** fibre orientation.

Note:

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

Available in **1/100 sizes** and according to the table.

Please note the minimum order quantities for configurable sizes:

Ø range 1.01 – 2.99 mm: **10 pieces**

Ø range 3.01 – 9.99 mm: **5 pieces**

Ø range 10.01 – 11.99 mm: **3 pieces**

Technical description

Flute length L_c	61 mm
Shank Ø D_s	10 mm
Feed f in GRP CRP	0.15 mm/rev.
recommended maximum drilling depth L_2	48.3 mm
Ø range (1/100 size) can be configured	8.01 - 8.99 mm
Tolerance nominal Ø	m7
Overall length L	103 mm
Shank tolerance	h6

Nominal Ø D _c	8.5 mm
Number of cutting edges Z	2
Coating	Diamond
Tool material	Solid carbide
Standard	Manufacturer's standard
Version	5xD
Point angle	90 degrees
Shank	DIN 6535 HA to h6
Through-coolant	no
Colour ring	black
Type of product	Jobber drill

User data

	Suitability	V _c	ISO code
PMMA acrylic	suitable only under restricted conditions	150 m/min	N
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
PVDF GF20	suitable	110 m/min	N
POM GF25	suitable	100 m/min	N
PA 66 GF30	suitable	90 m/min	N
PEEK GF30	suitable	80 m/min	N
PTFE CF25	suitable	90 m/min	N
PEEK CF30	suitable	80 m/min	N

Hybrids	suitable		
GRP, CRP	suitable	100 m/min	N
Graphite	suitable	340 m/min	N
wet maximum	suitable only under restricted conditions		
dry	suitable		
Air	suitable		