

Garant

Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC m6 (mm or inch): 8,5


Order data

Order number	123212 8,5
GTIN	4045197570338
Item class	11E

Description
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:

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

For process reliability when using the 12xD drill, an initial centre drilling with NC spotting drills No. 121068– 121130 is necessary.

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

Order form **HB**: with **No. 123214**.

Order form **HE**: with **No. 123212 + 129100HE**.

Standard: Manufacturer's standard

Tolerance nominal Ø: m6

Number of cutting edges Z: 2

Tolerance nominal Ø: m6

recommended maximum drilling depth L_2 : 107.3 mm

Overall length L: 162 mm

Shank Ø D_s : 10 mm

Feed f in stainless steel > 900 N/mm²: 0.15 mm/rev.

Technical description

Number of cutting edges Z	2
Feed f in stainless steel > 900 N/mm ²	0.15 mm/rev.

Nominal Ø D _c	8.5 mm
Flute length L _c	120 mm
Shank tolerance	h6
Tolerance nominal Ø	m6
Shank Ø D _s	10 mm
Overall length L	162 mm
Standard	Manufacturer's standard
recommended maximum drilling depth L ₂	107.3 mm
Coating	TiAlN
Tool material	Solid carbide
Version	12xD
Point angle	135 °
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 _c	ISO code
Steel < 500 N/mm ²	suitable	90 m/min	P
Steel < 750 N/mm ²	suitable	75 m/min	P
Steel < 900 N/mm ²	suitable	70 m/min	P
Steel < 1100 N/mm ²	suitable	55 m/min	P
Steel < 1400 N/mm ²	suitable	32 m/min	P
INOX < 900 N/mm ²	suitable	70 m/min	M
INOX > 900 N/mm ²	suitable	60 m/min	M
wet maximum	suitable		

wet minimum	suitable
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Services

Shank grinding Type HE	129100 HE
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