

Garant**Solid carbide drill plain shank DIN 6535 HA 180°, TiAlN, Ø DC m7: 8,6mm****Order data**

Order number	122506 8,6
GTIN	4045197744289
Item class	11E

Description**Version:**

Special point geometry for generating **180° flat-bottomed holes**. Low radial forces even when spot drilling on faces with up to 45° slope. Flute geometry for optimum chip evacuation. With 4 guide chamfers to stabilise the drill in the hole.

Advantage:

The 180° point angle permits drilling and counterboring in a single operation.

Recommendation:

When using the solid carbide 180° drill it is absolutely essential for process reliability:

- **when spot drilling on flat surfaces to drill a pilot hole 1×D using pilot drill No. 122736.**
- **when spot drilling on sloping surfaces up to 15° : reduce the feed rate f to 50 %, up to 30°: reduce the feed rate f to 40 % and up to 45°: reduce the feed rate f to 25 % of the stated value. After spot drilling, the normal feed rate value can be used.**

Note:

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

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

Form **HB**: order with **No. 122506 + 129100HB**.

Form **HE**: order with **No. 122506 + 129100HE**.

180° solid carbide drills for machining aluminium available on request.

Not suitable for generating counterbores for socket-head screws to DIN974-1.

Technical description

Feed f in steel < 900 N/mm ²	0.15 mm/rev.
Flute length L_c	47 mm
Shank Ø D_s	10 mm
Tolerance nominal Ø	m7

Data sheet

Number of cutting edges Z	2
Shank tolerance	h6
Standard	Manufacturer's standard
Overall length L	89 mm
Nominal $\varnothing D_c$	8.6 mm
recommended maximum drilling depth L_2	34.1 mm
Coating	TiAlN
Tool material	Solid carbide
Version	3xD
Point angle	180 degrees
Shank	DIN 6535 HA to h6
Use for drilling	limited convexity
Use for drilling	limited cross-drilling
Use for drilling	limited oblique spot drilling
Through-coolant	yes, with 25 bar
Pilot drill required	yes, pilot drill
Semi-Standard	yes
Colour ring	green
Type of product	Jobber drill

User data

	Suitability	V_c	ISO code
Steel < 500 N/mm ²	suitable	85 m/min	P
Steel < 750 N/mm ²	suitable	75 m/min	P
Steel < 900 N/mm ²	suitable	60 m/min	P
Steel < 1100 N/mm ²	suitable	50 m/min	P
INOX < 900 N/mm ²	suitable only under restricted conditions	45 m/min	M
GG(G)	suitable	90 m/min	K

Uni	suitable
wet maximum	suitable
wet minimum	suitable
Air	suitable
Suitable products	

<https://www.hoffmann-group.com/GB/en/hom/p/122506-8,6>