

Garant

Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, Ø DC m6 (Ø DC X = h7): W/L-25mm



Order data

Order number	122661 W/L-25
GTIN	4062406119867
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.

Recommendation:

Maximum drilling depth:

Flute length (see table) less 1.5×nominal Ø.

Attention:

Sizes **ending with X** = cutter Ø tolerance **h7**.

Note:

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

Standard: DIN 6537

Tolerance nominal Ø: m6

Number of cutting edges Z: 2

Tolerance nominal Ø: m6

recommended maximum drilling depth L_2 : 30.3 mm

Overall length L: 74 mm

Shank Ø D_s : 6 mm

Feed f in stainless steel > 900 N/mm²: 0.08 mm/rev.

Technical description

Tolerance nominal Ø	m6
Shank Ø D_s	6 mm

Feed f in stainless steel > 900 N/mm ²	0.08 mm/rev.
Standard	DIN 6537
Inch nominal Ø corresponds to	3.8 mm
recommended maximum drilling depth L ₂	30.3 mm
Flute length L _c	36 mm
Overall length L	74 mm
Number of cutting edges Z	2
Coating	TiAlN
Tool material	Solid carbide
	6×D
Point angle	140 °
Shank	DIN 6535 HB 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	170 m/min	P
Steel < 750 N/mm ²	suitable	140 m/min	P
Steel < 900 N/mm ²	suitable	130 m/min	P
Steel < 1100 N/mm ²	suitable	110 m/min	P
Steel < 1400 N/mm ²	suitable	70 m/min	P
INOX < 900 N/mm ²	suitable	90 m/min	M
INOX > 900 N/mm ²	suitable	80 m/min	M
GG(G)	suitable	95 m/min	K
Uni	suitable		

wet maximum	suitable
wet minimum	suitable
Air	suitable