

Garant

Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, Ø DC m6: 5/16mm



Order data

| | |
|--------------|---------------|
| Order number | 123010 5/16 |
| GTIN | 4062406120993 |
| 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 $L_c = L_2 + 1.5 \times D_c$.

Technical description

| | |
|---|-------------------------|
| Shank Ø D_s | 8 mm |
| Standard | Manufacturer's standard |
| Feed f in stainless steel > 900 N/mm ² | 0.12 mm/rev. |
| Number of cutting edges Z | 2 |
| Flute length L_c | 76 mm |
| Tolerance nominal Ø | m6 |
| Overall length L | 114 mm |
| recommended maximum drilling depth L_2 | 64.09 mm |
| Inch nominal Ø corresponds to | 7,94 mm |
| Coating | TiAlN |
| Tool material | Solid carbide |

| | |
|--------------------|-------------------|
| Version | 8xD |
| Point angle | 140 degrees |
| 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 | 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 |
| Uni | suitable | | |
| wet maximum | suitable | | |
| wet minimum | suitable | | |