Garant

# Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, ∅ DC m6 (mm or inch): 3/16

## Order data

| | |
|---|---|
| Order number | 123214 3/16 |
| GTIN | 4062406121181 |
| 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 ∅ 3.8 mm. Up to 3.7 mm ∅ 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 12×D drill, an initial centre drilling with No. 121068 – 121130 is necessary.
Standard: Manufacturer's standard
Tolerance nominal ∅: m6
Number of cutting edges Z: 2
recommended maximum drilling depth $L_2$: 70.86 mm
Tolerance nominal ∅: m6
Overall length L: 116 mm
Shank ∅ $D_s$: 6 mm
Feed f in stainless steel > 900 N/mm$^2$: 0.08 mm/rev.

## Technical description

| | |
|---|---|
| Number of cutting edges Z | 2 |
| Shank ∅ $D_s$ | 6 mm |
| Flute length $L_c$ | 78 mm |
| Inch nominal ∅ corresponds to | 4.76 mm |

| | |
|---|---|
| Tolerance nominal Ø | m6 |
| recommended maximum drilling depth $L_2$ | 70.86 mm |
| Overall length L | 116 mm |
| Standard | Manufacturer’s standard |
| Feed f in stainless steel > 900 N/mm² | 0.08 mm/rev. |
| Coating | TiAlN |
| Tool material | Solid carbide |
| Version | 12×D |
| Point angle | 135 ° |
| 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/mm² | suitable | 90 m/min | P |
| Steel < 750 N/mm² | suitable | 75 m/min | P |
| Steel < 900 N/mm² | suitable | 70 m/min | P |
| Steel < 1100 N/mm² | suitable | 55 m/min | P |
| Steel < 1400 N/mm² | suitable | 32 m/min | P |
| INOX < 900 N/mm² | suitable | 70 m/min | M |
| INOX > 900 N/mm² | suitable | 60 m/min | M |
| Uni | suitable | | |
| wet maximum | suitable | | |
| wet minimum | suitable | | |