

**Garant**
**Solid carbide HPC drill Weldon shank DIN 6535 HB, DLC, Ø DC h7: 6,9mm**


## Order data

Order number	122307 6,9
GTIN	4045197756831
Item class	11E

## Description

### Version:

**DLC coating  $sp^2$**  of the latest generation with **low coefficient of friction** results in **outstanding chip clearance**. For **high-performance milling** of **aluminium materials**. **High roundness** and **alignment accuracy of the deep hole**, thanks to **6 guide chamfers**.

### Note:

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

## Technical description

Flute length $L_c$	34 mm
Nominal Ø $D_c$	6.9 mm
Overall length $L$	79 mm
Tolerance nominal Ø	h7
Shank tolerance	h6
Standard	DIN 6537 K
Shank Ø $D_s$	8 mm
Feed $f$ in aluminium short-chipping	0.45 mm/rev.
Number of cutting edges $Z$	2
recommended maximum drilling depth $L_2$	23.7 mm
Coating	DLC
Tool material	solid carbide

Version	4xD
Type	W
Point angle	135 degrees
Shank	DIN 6535 HB to h6
Through-coolant	Yes, with 25 bar
Machining strategy	HPC
Semi-Standard	yes
Colour ring	yellow
Type of product	Jobber drill

### User data

	Suitability	V <sub>c</sub>	ISO code
Alu plastics	suitable	360 m/min	N
Aluminium (short chipping)	suitable	400 m/min	N
Alu > 10% Si	suitable	350 m/min	N
PMMA acrylic	suitable	150 m/min	N
PEEK	suitable	120 m/min	N
PVDF GF20	suitable	90 m/min	N
PA 66 GF30	suitable	80 m/min	N
PEEK GF30	suitable	70 m/min	N
PTFE CF25	suitable	80 m/min	N
Cu	suitable	160 m/min	N
CuZn	suitable	200 m/min	N
GRP	suitable	80 m/min	N
CRP	suitable	80 m/min	N
wet maximum	suitable		
wet minimum	suitable		

