

## Garant

### Solid carbide HPC drill Weldon shank DIN 6535 HB, DLC, Ø DC h7: 13,8mm



#### Order data

Order number	122809 13,8
GTIN	4045197759382
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

Shank Ø $D_s$	14 mm
Number of cutting edges Z	2
Overall length L	178 mm
Standard	Manufacturer's standard
Tolerance nominal Ø	h7
Nominal Ø $D_c$	13.8 mm
Feed f in aluminium short-chipping	0.65 mm/rev.
Shank tolerance	h6
Flute length $L_c$	131 mm
recommended maximum drilling depth $L_2$	110.3 mm
Coating	DLC
Tool material	solid carbide

Version	8xD
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	325 m/min	N
Aluminium (short chipping)	suitable	360 m/min	N
Alu > 10% Si	suitable	315 m/min	N
PMMA acrylic	suitable	135 m/min	N
PEEK	suitable	110 m/min	N
PVDF GF20	suitable	80 m/min	N
PA 66 GF30	suitable	70 m/min	N
PEEK GF30	suitable	60 m/min	N
PTFE CF25	suitable	70 m/min	N
Cu	suitable	140 m/min	N
CuZn	suitable	160 m/min	N
GRP	suitable	70 m/min	N
CRP	suitable	70 m/min	N
wet maximum	suitable		
wet minimum	suitable		

