

**Garant**
**Solid carbide HPC drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 6,8mm**

**Order data**

Order number	122385 6,8
GTIN	4045197388957
Item class	11E

**Description**
**Version:**

Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry**. **Straight major cutting edges** with slightly honed edges and special flute profile produce **short chips**.

**Note:**

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

**Technical description**

Feed $f$ in stainless steel < 900 N/mm <sup>2</sup>	0.12 mm/rev.
Nominal Ø $D_c$	6.8 mm
Number of cutting edges $Z$	2
Shank tolerance	h6
Flute length $L_c$	34 mm
Tolerance nominal Ø	h7
Shank Ø $D_s$	8 mm
Overall length $L$	79 mm
Standard	DIN 6537 K
recommended maximum drilling depth $L_2$	23.8 mm
Coating	TiAlN
Tool material	Solid carbide

Version	4xD
Point angle	135 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 <sub>c</sub>	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	245 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	110 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	90 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	85 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	60 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable only under restricted conditions	35 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	55 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	50 m/min	M
Ti > 850 N/mm <sup>2</sup>	suitable	35 m/min	S
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable		
Air	suitable		