

Garant
Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 3,3mm

Order data

| | |
|--------------|---------------|
| Order number | 123115 3,3 |
| GTIN | 4045197401601 |
| Item class | 11E |

Description
Version:

Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry**.

Particularly high alignment accuracy due to **4 guide chamfers** which stabilise the drill even at extreme depths!

Straight major cutting edges with honed edges and special flute profile for **short chips**, even on long chipping materials.

Advantage:

High process reliability and surface quality of the hole.

Note:

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

Technical description

| | |
|--|-------------------------|
| Flute length L_c | 40 mm |
| Nominal $\varnothing D_c$ | 3.3 mm |
| Shank tolerance | h6 |
| Feed f in stainless steel $< 900 \text{ N/mm}^2$ | 0.08 mm/rev. |
| Number of cutting edges Z | 2 |
| Tolerance nominal \varnothing | h7 |
| Shank $\varnothing D_s$ | 6 mm |
| Overall length L | 80 mm |
| Standard | Manufacturer's standard |

| | |
|--|-------------------|
| recommended maximum drilling depth L_2 | 35.1 mm |
| Coating | TiAlN |
| Tool material | Solid carbide |
| Version | 10xD |
| 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_c | ISO code |
|-------------------------------|---|-----------|----------|
| Aluminium (short chipping) | suitable only under restricted conditions | 200 m/min | N |
| Alu > 10% Si | suitable only under restricted conditions | 180 m/min | N |
| Steel < 500 N/mm ² | suitable | 110 m/min | P |
| Steel < 750 N/mm ² | suitable | 80 m/min | P |
| Steel < 900 N/mm ² | suitable | 70 m/min | P |
| INOX < 900 N/mm ² | suitable | 65 m/min | M |
| INOX > 900 N/mm ² | suitable | 55 m/min | M |
| Ti > 850 N/mm ² | suitable | 25 m/min | S |
| Uni | suitable only under restricted conditions | | |
| wet maximum | suitable | | |
| wet minimum | suitable | | |

