

Garant

Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, Ø DC m6 (mm or inch): 7



Order data

| | |
|--------------|---------------|
| Order number | 123214 7 |
| GTIN | 4045197573117 |
| 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 Ø 3.8 mm. Up to 3.7 mm Ø 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 Ø: m6

Number of cutting edges Z: 2

recommended maximum drilling depth L_2 : 97.5 mm

Tolerance nominal Ø: m6

Overall length L: 146 mm

Shank Ø D_s : 8 mm

Feed f in stainless steel > 900 N/mm²: 0.12 mm/rev.

Technical description

| | |
|---|--------------|
| Feed f in stainless steel > 900 N/mm ² | 0.12 mm/rev. |
| Flute length L_c | 108 mm |
| Nominal Ø D_c | 7 mm |
| Number of cutting edges Z | 2 |

| | |
|--|-------------------------|
| Shank tolerance | h6 |
| Tolerance nominal \varnothing | m6 |
| Shank $\varnothing D_s$ | 8 mm |
| Overall length L | 146 mm |
| Standard | Manufacturer's standard |
| recommended maximum drilling depth L_2 | 97.5 mm |
| Coating | TiAlN |
| Tool material | Solid carbide |
| Version | 12xD |
| 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/mm ² | suitable | 90 m/min | P |
| Steel < 750 N/mm ² | suitable | 75 m/min | P |
| Steel < 900 N/mm ² | suitable | 70 m/min | P |
| Steel < 1100 N/mm ² | suitable | 55 m/min | P |
| Steel < 1400 N/mm ² | suitable | 32 m/min | P |
| INOX < 900 N/mm ² | suitable | 70 m/min | M |
| INOX > 900 N/mm ² | suitable | 60 m/min | M |
| Uni | suitable | | |
| wet maximum | suitable | | |
| wet minimum | suitable | | |

