

Garant

Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, Ø DC m6 (Ø DC X = h7): 4,15mm



Order data

| | |
|--------------|---------------|
| Order number | 122661 4,15 |
| GTIN | 4045197583260 |
| 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.

Attention:

Sizes **ending with X** = cutter Ø tolerance **h7**.

Note:

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

Technical description

| | |
|--|--------------|
| Flute length L_c | 36 mm |
| Feed f in stainless steel $> 900 \text{ N/mm}^2$ | 0.08 mm/rev. |
| Nominal Ø D_c | 4.15 mm |
| Number of cutting edges Z | 2 |
| Shank tolerance | h6 |
| Tolerance nominal Ø | m6 |
| Shank Ø D_s | 6 mm |
| Overall length L | 74 mm |
| Standard | DIN 6537 |

| | |
|--|-------------------|
| recommended maximum drilling depth L_2 | 29.8 mm |
| Coating | TiAlN |
| Tool material | Solid carbide |
| Version | 6×D |
| Point angle | 140 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 |
|--------------------------------|-------------|-----------|----------|
| Steel < 500 N/mm ² | suitable | 170 m/min | P |
| Steel < 750 N/mm ² | suitable | 140 m/min | P |
| Steel < 900 N/mm ² | suitable | 130 m/min | P |
| Steel < 1100 N/mm ² | suitable | 110 m/min | P |
| Steel < 1400 N/mm ² | suitable | 70 m/min | P |
| INOX < 900 N/mm ² | suitable | 90 m/min | M |
| INOX > 900 N/mm ² | suitable | 80 m/min | M |
| GG(G) | suitable | 95 m/min | K |
| Uni | suitable | | |
| wet maximum | suitable | | |
| wet minimum | suitable | | |
| Air | suitable | | |