Garant

# Solid carbide HPC drill, plain shank DIN 6535 HB, TiAlN, ∅ DC m6 (∅ DC X = h7): 9,3mm

## Order data

| | |
|---|---|
| Order number | 122661 9,3 |
| GTIN | 4045197457813 |
| 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 ∅ 3.8 mm. Up to 3.7 mm ∅ 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 ∅ tolerance **h7.**
**Note:**
Flute length $L_C = L_2 + 1.5 \times D_C$.

## Technical description

| | |
|---|---|
| Flute length $L_c$ | 61 mm |
| Nominal ∅ $D_C$ | 9.3 mm |
| Shank tolerance | h6 |
| Feed f in stainless steel > 900 N/mm$^2$ | 0.15 mm/rev. |
| Number of cutting edges Z | 2 |
| Tolerance nominal ∅ | m6 |
| Shank ∅ $D_s$ | 10 mm |
| Overall length L | 103 mm |
| Standard | DIN 6537 |

| | |
|---|---|
| recommended maximum drilling depth $L_2$ | 47.1 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/mm² | suitable | 170 m/min | P |
| Steel < 750 N/mm² | suitable | 140 m/min | P |
| Steel < 900 N/mm² | suitable | 130 m/min | P |
| Steel < 1100 N/mm² | suitable | 110 m/min | P |
| Steel < 1400 N/mm² | suitable | 70 m/min | P |
| INOX < 900 N/mm² | suitable | 90 m/min | M |
| INOX > 900 N/mm² | suitable | 80 m/min | M |
| GG(G) | suitable | 95 m/min | K |
| Uni | suitable | | |
| wet maximum | suitable | | |
| wet minimum | suitable | | |
| Air | suitable | | |