

## Garant

**Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, Ø DC m6 (Ø DC X = h7): 8,2mm**



### Order data

|              |               |
|--------------|---------------|
| Order number | 122661 8,2    |
| GTIN         | 4045197457707 |
| 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 $L_c$                                 | 61 mm        |
| Feed $f$ in stainless steel $> 900 \text{ N/mm}^2$ | 0.15 mm/rev. |
| Nominal Ø $D_c$                                    | 8.2 mm       |
| Shank tolerance                                    | h6           |
| Number of cutting edges $Z$                        | 2            |
| Tolerance nominal Ø                                | m6           |
| Shank Ø $D_s$                                      | 10 mm        |
| Overall length $L$                                 | 103 mm       |
| Standard   | DIN 6537     |

|   |                   |
|---|-------------------|
| recommended maximum drilling depth L <sub>2</sub> | 48.7 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 <sub>c</sub> | ISO code |
|--------------------------------|-------------|----------------|----------|
| Steel < 500 N/mm <sup>2</sup>  | suitable    | 170 m/min      | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable    | 140 m/min      | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable    | 130 m/min      | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable    | 110 m/min      | P        |
| Steel < 1400 N/mm <sup>2</sup> | suitable    | 70 m/min       | P        |
| INOX < 900 N/mm <sup>2</sup>   | suitable    | 90 m/min       | M        |
| INOX > 900 N/mm <sup>2</sup>   | suitable    | 80 m/min       | M        |
| GG(G)                          | suitable    | 95 m/min       | K        |
| Uni                            | suitable    |                |          |
| wet maximum                    | suitable    |                |          |
| wet minimum                    | suitable    |                |          |
| Air                            | suitable    |                |          |