

## Garant

### Solid carbide HPC drill type FS Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 9,8 mm



#### Order data

|              |               |
|--------------|---------------|
| Order number | 122675 9,8    |
| GTIN         | 4045197398277 |
| Item class   | 11E           |

#### Description

##### Version:

**Particularly strong** due to strengthened core and **special profile**. Special point geometry. **High concentricity** and **long tool life**.

**Precision drilling qualities.**

##### Recommendation:

##### Maximum drilling depth:

Flute length (see table) less 1.5×nominal Ø.

##### Note:

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

Standard: DIN 6537

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

Tolerance nominal Ø: h7

recommended maximum drilling depth  $L_2$ : 46.3 mm

Overall length L: 103 mm

Shank Ø  $D_s$ : 10 mm

Feed f in titanium > 850 N/mm<sup>2</sup>: 0.12 mm/rev.

#### Technical description

|                                            |              |
|--------------------------------------------|--------------|
| Feed f in titanium > 850 N/mm <sup>2</sup> | 0.12 mm/rev. |
| Nominal Ø $D_c$                            | 9.8 mm       |
| Number of cutting edges Z                  | 2            |
| Flute length $L_c$                         | 61 mm        |

|                                          |                   |
|------------------------------------------|-------------------|
| Shank tolerance                          | h6                |
| Tolerance nominal $\varnothing$          | h7                |
| Shank $\varnothing D_s$                  | 10 mm             |
| Overall length L                         | 103 mm            |
| Standard                                 | DIN 6537          |
| recommended maximum drilling depth $L_2$ | 46.3 mm           |
| Coating                                  | TiAlN             |
| Tool material                            | Solid carbide     |
|                                          | 6×D               |
| Type                                     | FS                |
| Point angle                              | 140°              |
| Shank                                    | DIN 6535 HB to h6 |
| Through-coolant                          | yes, with 25 bar  |
| Machining strategy                       | HPC               |
| Semi-Standard                            | yes               |
| Colour ring                              | pink              |
| Type of product                          | Jobber drill      |

## User data

|                                | Suitability                               | $V_c$     | ISO code |
|--------------------------------|-------------------------------------------|-----------|----------|
| Alu plastics                   | suitable                                  | 260 m/min | N        |
| Aluminium (short chipping)     | suitable                                  | 240 m/min | N        |
| Alu > 10% Si                   | suitable                                  | 160 m/min | N        |
| Steel < 500 N/mm <sup>2</sup>  | suitable                                  | 110 m/min | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable                                  | 90 m/min  | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable                                  | 85 m/min  | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable                                  | 60 m/min  | P        |
| Steel < 1400 N/mm <sup>2</sup> | suitable only under restricted conditions | 30 m/min  | P        |

|                              |          |          |   |
|------------------------------|----------|----------|---|
| INOX < 900 N/mm <sup>2</sup> | suitable | 40 m/min | M |
| INOX > 900 N/mm <sup>2</sup> | suitable | 35 m/min | M |
| Ti > 850 N/mm <sup>2</sup>   | suitable | 35 m/min | S |
| wet maximum                  | suitable |          |   |
| wet minimum                  | suitable |          |   |
| Air                          | suitable |          |   |