

Garant

Solid carbide HPC drill type FS Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 4,6 mm



Order data

| | |
|--------------|---------------|
| Order number | 122675 4,6 |
| GTIN | 4045197397812 |
| 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 : 37.1 mm

Overall length L: 82 mm

Shank Ø D_s : 6 mm

Feed f in titanium > 850 N/mm²: 0.04 mm/rev.

Technical description

| | |
|--|--------------|
| Nominal Ø D_c | 4.6 mm |
| Shank tolerance | h6 |
| Feed f in titanium > 850 N/mm ² | 0.04 mm/rev. |
| Number of cutting edges Z | 2 |

| | |
|--|-------------------|
| Flute length L_c | 44 mm |
| Tolerance nominal \varnothing | h7 |
| Shank $\varnothing D_s$ | 6 mm |
| Overall length L | 82 mm |
| Standard | DIN 6537 |
| recommended maximum drilling depth L_2 | 37.1 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 ² | suitable | 110 m/min | P |
| Steel < 750 N/mm ² | suitable | 90 m/min | P |
| Steel < 900 N/mm ² | suitable | 85 m/min | P |
| Steel < 1100 N/mm ² | suitable | 60 m/min | P |
| Steel < 1400 N/mm ² | suitable only under restricted conditions | 30 m/min | P |

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