

**Garant**
**Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, Ø DC p6: 8,5mm**

**Order data**

Order number	122738 8,5
GTIN	4045197567727
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. With **140° point angle** and special **j6 cutting edge tolerance** for optimum generation of a pilot hole.

**Note:**

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

For deep-hole drilling deeper than  $12 \times D$  a pilot hole is recommended, and for deep-hole drilling from  $20 \times D$  to  $30 \times D$  it is essential.

**The generation of a pilot hole always improves process reliability.**

**Technical description**

Shank tolerance	h6
Flute length $L_c$	61 mm
Feed $f$ in steel $< 1100 \text{ N/mm}^2$	0.27 mm/rev.
Nominal Ø $D_c$	8.5 mm
Number of cutting edges $Z$	2
Tolerance nominal Ø	p6
Shank Ø $D_s$	10 mm
Overall length $L$	103 mm
Standard	DIN 6537

recommended maximum drilling depth $L_2$	48.3 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	green
Type of product	Jobber drill

## User data

	Suitability	$V_c$	ISO code
Steel < 500 N/mm <sup>2</sup>	suitable	170 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	130 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	120 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	110 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	65 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	75 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	70 m/min	M
GG(G)	suitable	95 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable		
Air	suitable		