

**Garant**
**Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, Ø DC p6: 11,8mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 122738 11,8   |
| GTIN         | 4045197567833 |
| 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×D a pilot hole is recommended, and for deep-hole drilling from 20×D to 30×D it is essential.

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

**Technical description**

|  |              |
|--|--------------|
| Feed f in steel < 1100 N/mm <sup>2</sup> | 0.27 mm/rev. |
| Nominal Ø D <sub>c</sub>                 | 11.8 mm      |
| Number of cutting edges Z                | 2            |
| Flute length L <sub>c</sub>              | 71 mm        |
| Shank tolerance                          | h6           |
| Tolerance nominal Ø                      | p6           |
| Shank Ø D <sub>s</sub>                   | 12 mm        |
| Overall length L                         | 118 mm       |
| Standard                                 | DIN 6537     |

|  |                   |
|--|-------------------|
| recommended maximum drilling depth $L_2$ | 53.3 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    |           |          |