

Garant
Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 16,5mm


Order data

| | |
|--------------|---------------|
| Order number | 122505 16,5 |
| GTIN | 4045197392411 |
| Item class | 11E |

Description

Version:

Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry**. **Convex cutting edges** with honed edges and special flute profile for **short chips**, even on long chipping materials.

Note:

NEW GENERATION AVAILABLE!

Recommended successor products are No. 122426 and 122436.

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

Technical description

| | |
|--|--------------|
| Feed f in steel < 1100 N/mm ² | 0.35 mm/rev. |
| Shank tolerance | h6 |
| Flute length L_c | 73 mm |
| Number of cutting edges Z | 2 |
| Nominal Ø D_c | 16.5 mm |
| Tolerance nominal Ø | h7 |
| Shank Ø D_s | 18 mm |
| Overall length L | 123 mm |
| Standard | DIN 6537 K |
| recommended maximum drilling depth L_2 | 48.3 mm |
| Coating | TiAlN |

| | |
|--------------------|-------------------|
| Tool material | Solid carbide |
| Version | 4xD |
| Point angle | 140 degrees |
| Shank | DIN 6535 HB to h6 |
| Through-coolant | yes, with 25 bar |
| Machining strategy | HPC |
| Colour ring | green |
| Type of product | Jobber drill |

User data

| | Suitability | V _c | ISO code |
|--------------------------------|---|----------------|----------|
| Steel < 500 N/mm ² | suitable only under restricted conditions | 120 m/min | P |
| Steel < 750 N/mm ² | suitable | 100 m/min | P |
| Steel < 900 N/mm ² | suitable | 85 m/min | P |
| Steel < 1100 N/mm ² | suitable | 65 m/min | P |
| Steel < 1400 N/mm ² | suitable | 35 m/min | P |
| INOX < 900 N/mm ² | suitable only under restricted conditions | 30 m/min | M |
| Ti > 850 N/mm ² | suitable only under restricted conditions | 35 m/min | S |
| GG(G) | suitable | 70 m/min | K |
| Uni | suitable | | |
| wet maximum | suitable | | |
| wet minimum | suitable | | |
| Air | suitable | | |