

Garant
Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 18,5mm


Order data

Order number	122765 18,5
GTIN	4045197399410
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:

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

NEW GENERATION AVAILABLE!

Recommended successor products are No. 122716 and 122726.

Technical description

Number of cutting edges Z	2
Nominal Ø D _c	18.5 mm
Feed f in steel < 1100 N/mm ²	0.35 mm/rev.
Shank tolerance	h6
Flute length L _c	101 mm
Tolerance nominal Ø	h7
Shank Ø D _s	20 mm
Overall length L	153 mm
Standard	DIN 6537
recommended maximum drilling depth L ₂	73.3 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 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
Steel < 55 HRC	suitable	28 m/min	H
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		
Air	suitable		

