

Garant
Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, Ø DC m6: 4,2 mm

Order data

Order number	122432 4,2
GTIN	4045197536860
Item class	11E

Description
Version:

Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry**. Excellent chip evacuation due to **4 internal coolant channels**. **Straight cutting edges** with honed edges and special flute profile for **short chips**. **Special coating** for the **best tool life** and **high metal removal rates**.

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 K

Tolerance nominal Ø: m6

Number of cutting edges Z: 2

Tolerance nominal Ø: m6

recommended maximum drilling depth L_2 : 17.7 mm

Overall length L: 66 mm

Shank Ø D_s : 6 mm

Feed f in Inconel®: 0.04 mm/rev.

Technical description

Feed f in Inconel®	0.04 mm/rev.
Flute length L_c	24 mm
Nominal Ø D_c	4.2 mm
Shank tolerance	h6

Number of cutting edges Z	2
Tolerance nominal \varnothing	m6
Shank $\varnothing D_s$	6 mm
Overall length L	66 mm
Standard	DIN 6537 K
recommended maximum drilling depth L_2	17.7 mm
Coating	TiAlN
Tool material	Solid carbide
	4xD
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
Ti > 850 N/mm ²	suitable	40 m/min	S
Inconel	suitable	35 m/min	S
wet maximum	suitable		