

## Garant

**Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, Ø DC m6: 8,6 mm**



### Order data

Order number	122432 8,6
GTIN	4045197539823
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  $L_2$ : 34.1 mm

Overall length L: 89 mm

Shank Ø  $D_s$ : 10 mm

Feed f in Inconel®: 0.12 mm/rev.

### Technical description

Feed f in Inconel®	0.12 mm/rev.
Nominal Ø $D_c$	8.6 mm
Flute length $L_c$	47 mm
Shank tolerance	h6

Number of cutting edges Z	2
Tolerance nominal $\varnothing$	m6
Shank $\varnothing D_s$	10 mm
Overall length L	89 mm
Standard	DIN 6537 K
recommended maximum drilling depth $L_2$	34.1 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 <sup>2</sup>	suitable	40 m/min	S
Inconel	suitable	35 m/min	S
wet maximum	suitable		