

**Garant**
**Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, Ø DC m6: 10,8 mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 122432 10,8   |
| GTIN         | 4045197539953 |
| 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  $L_2$ : 38.8 mm

Overall length L: 102 mm

Shank Ø  $D_s$ : 12 mm

Feed f in Inconel®: 0.12 mm/rev.

**Technical description**

|                           |         |
|---------------------------|---------|
| Flute length $L_c$        | 55 mm   |
| Number of cutting edges Z | 2       |
| Nominal Ø $D_c$           | 10.8 mm |
| Shank tolerance           | h6      |

|   |                   |
|---|-------------------|
| Feed f in Inconel®                                | 0.12 mm/rev.      |
| Tolerance nominal Ø                               | m6                |
| Shank Ø D <sub>s</sub>                            | 12 mm             |
| Overall length L                                  | 102 mm            |
| Standard  | DIN 6537 K        |
| recommended maximum drilling depth L <sub>2</sub> | 38.8 mm           |
| Coating   | TiAlN             |
| Tool material                                     | Solid carbide     |
|   | 4×D               |
| 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 <sub>c</sub> | ISO code |
|----------------------------|-------------|----------------|----------|
| Ti > 850 N/mm <sup>2</sup> | suitable    | 40 m/min       | S        |
| Inconel                    | suitable    | 35 m/min       | S        |
| wet maximum                | suitable    |                |          |