

**Garant**
**Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, Ø DC m6: 9,1 mm**

**Order data**

Order number	122432 9,1
GTIN	4045197539878
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  $L_c = L_2 + 1.5 \times D_c$ -

Machining strategy: HPC

Standard: DIN 6537 K

Tolerance nominal Ø: m6

Number of cutting edges Z: 2

Semi-Standard: yes

Tolerance nominal Ø: m6

recommended maximum drilling depth  $L_2$ : 33.4 mm

Overall length L: 89 mm

Shank Ø  $D_s$ : 10 mm

Feed f in Inconel®: 0.12 mm/rev.

**Technical description**

Shank tolerance	h6
Number of cutting edges Z	2
Nominal Ø $D_c$	9.1 mm

Flute length $L_c$	47 mm
Feed $f$ in Inconel®	0.12 mm/rev.
Tolerance nominal $\varnothing$	m6
Shank $\varnothing D_s$	10 mm
Overall length $L$	89 mm
Standard	DIN 6537 K
recommended maximum drilling depth $L_2$	33.4 mm
Semi-Standard	yes
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	4xD
Point angle	140 degrees
Shank	DIN 6535 HB to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Colour ring	pink
Type of product	Jobber drill