

**Garant**
**Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, Ø DC m6: 18,5mm**

**Order data**

Order number	123010 18,5
GTIN	4045197572929
Item class	11E

**Description**
**Version:**

Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry**. High roundness and alignment accuracy of the deep hole, thanks to **4 guide chamfers**. Outstanding chip evacuation due to **4 internal cooling channels** from Ø 3.8 mm. Up to 3.7 mm Ø with 2 internal cooling channels. **Straight major cutting edges** with honed edges and special flute profile for **short chips**, even on long chipping materials.

**Note:**

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

**Technical description**

Flute length $L_c$	190 mm
Nominal Ø $D_c$	18.5 mm
Feed $f$ in stainless steel > 900 N/mm <sup>2</sup>	0.25 mm/rev.
Shank tolerance	h6
Number of cutting edges $Z$	2
Tolerance nominal Ø	m6
Shank Ø $D_s$	20 mm
Overall length $L$	243 mm
Standard	Manufacturer's standard
recommended maximum drilling depth $L_2$	162.3 mm
Coating	TiAlN

Tool material	Solid carbide
Version	8×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	blue
Type of product	Jobber drill

### User data

	Suitability	V <sub>c</sub>	ISO code
Steel < 500 N/mm <sup>2</sup>	suitable	90 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	75 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	70 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	55 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	32 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	70 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	60 m/min	M
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable		