

Garant
Solid carbide HPC drill Weldon shank DIN 6535 HB, DLC, Ø DC p6: 7,5mm


Order data

| | |
|--------------|---------------|
| Order number | 122608 7,5 |
| GTIN | 4045197568878 |
| Item class | 11E |

Description

Version:

Spiral fluted, with **6 guide chamfers** and internal cooling channels.

New generation of high performance pilot drills in the HPC range.

With **140° point angle** and special **p6 cutting edge tolerance** for optimum generation of a pilot hole. High alignment accuracy and **roundness of the pilot hole**.

Note:

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

For deep-hole drilling deeper than $16 \times D$ a pilot hole is recommended, and for deep-hole drilling from $20 \times D$ to $30 \times D$ it is essential. **The generation of a pilot hole always improves process reliability.**

Technical description

| | |
|--|--------------|
| Flute length L_c | 53 mm |
| Number of cutting edges Z | 2 |
| Shank tolerance | h6 |
| Feed f in aluminium short-chipping | 0.36 mm/rev. |
| Nominal $\varnothing D_c$ | 7.5 mm |
| Tolerance nominal \varnothing | p6 |
| Shank $\varnothing D_s$ | 8 mm |
| Overall length L | 91 mm |
| Standard | DIN 6537 |
| recommended maximum drilling depth L_2 | 41.8 mm |

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|--------------------|-------------------|
| Coating | DLC |
| Tool material | Solid carbide |
| Version | 6xD |
| Type | W |
| Point angle | 140 degrees |
| Shank | DIN 6535 HB to h6 |
| Through-coolant | yes, with 25 bar |
| Machining strategy | HPC |
| Semi-Standard | yes |
| Colour ring | yellow |
| Type of product | Jobber drill |

User data

| | Suitability | V _c | ISO code |
|----------------------------|-------------|----------------|----------|
| Alu plastics | suitable | 360 m/min | N |
| Aluminium (short chipping) | suitable | 400 m/min | N |
| Alu > 10% Si | suitable | 350 m/min | N |
| PMMA acrylic | suitable | 150 m/min | N |
| PEEK | suitable | 120 m/min | N |
| PVDF GF20 | suitable | 90 m/min | N |
| PA 66 GF30 | suitable | 80 m/min | N |
| PEEK GF30 | suitable | 70 m/min | N |
| PTFE CF25 | suitable | 80 m/min | N |
| Cu | suitable | 160 m/min | N |
| CuZn | suitable | 200 m/min | N |
| GRP | suitable | 80 m/min | N |
| CRP | suitable | 80 m/min | N |
| wet maximum | suitable | | |

wet minimum

suitable