Garant

Solid carbide HPC drill, plain shank DIN 6535 HB, DLC, ∅ DC p6: 6mm

Order data

Order number	122608 6
GTIN	4045197568823
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×D a pilot hole is recommended, and for deep-hole drilling from 20×D to 30×D it is essential. **The generation of a pilot hole always improves process reliability.**

Technical description

Shank tolerance	h6
Feed f in aluminium short-chipping	0.36 mm/rev.
Flute length L_c	44 mm
Number of cutting edges Z	2
Nominal ∅ D_C	6 mm
Tolerance nominal ∅	p6
Shank ∅ D_s	6 mm
Overall length L	82 mm
Standard	DIN 6537
recommended maximum drilling depth L_2	35 mm

Coating	DLC
Tool material	Solid carbide
Version	6×D
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