

Garant
Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 18,06-Xmm

Order data

Order number	122765 18,06-X
GTIN	4062406522711
Item class	11E

Description
Version:

Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry**.

Convex cutting edges with honed edges and special flute profile for **short chips**, even on long chipping materials.

Note:

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

NEW GENERATION AVAILABLE!

Recommended successor products are No. 122716 and 122726. Delivery time: 12 working weeks

Minimum order quantity: 3 pcs

Items made to order for a specific customer: Cancellation only up to a maximum of 3 working days after receipt of order acknowledgement. Items cannot be returned. We reserve the right to over-deliver or under-deliver by $\pm 10\%$ (minimum 1 piece).

Technical description

Ø range	18.06 - 20.05 mm
Overall length L	153 mm
Standard	DIN 6537
Shank tolerance	h6
Flute length L_c	101 mm
Feed f in steel < 1100 N/mm ²	0.35 mm/rev.

Shank $\varnothing D_s$	20 mm
Tolerance nominal \varnothing	h7
Number of cutting edges Z	2
Coating	TiAlN
Tool material	Solid carbide
Version	6xD
Point angle	140 degrees
Shank	DIN 6535 HB to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Semi-Standard	yes
Colour ring	green
Type of product	Jobber drill

User data

	Suitability	V_c	ISO code
Steel < 500 N/mm ²	suitable only under restricted conditions	120 m/min	P
Steel < 750 N/mm ²	suitable	100 m/min	P
Steel < 900 N/mm ²	suitable	85 m/min	P
Steel < 1100 N/mm ²	suitable	65 m/min	P
Steel < 1400 N/mm ²	suitable	35 m/min	P
Steel < 55 HRC	suitable	28 m/min	H
INOX < 900 N/mm ²	suitable only under restricted conditions	30 m/min	M
Ti > 850 N/mm ²	suitable only under restricted conditions	35 m/min	S
GG(G)	suitable	70 m/min	K
Uni	suitable		
wet maximum	suitable		

Air

suitable