

Garant

Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, Ø DC m6 (mm or inch): 18,06-X



Order data

Order number	123214 18,06-X
GTIN	4062406523411
Item class	11E

Description

IMPORTANT: item is configurable

Ø range: 18.06 - 20.05 mm

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 $L_c = L_2 + 1.5 \times D_c$.

For process reliability when using the 12xD drill, an initial centre drilling with No. 121068 – 121130 is necessary. 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).

Standard: Manufacturer's standard

Tolerance nominal Ø: m6

Number of cutting edges Z: 2

Tolerance nominal Ø: m6

Overall length L: 310 mm

Shank Ø D_s : 20 mm

Feed f in stainless steel $> 900 \text{ N/mm}^2$: 0.25 mm/rev.

Technical description

Feed f in stainless steel > 900 N/mm ²	0.25 mm/rev.
Tolerance nominal Ø	m6
Ø range	18.06 - 20.05 mm
Standard	Manufacturer's standard
Shank tolerance	h6
Number of cutting edges Z	2
Overall length L	310 mm
Shank Ø D _s	20 mm
Flute length L _c	258 mm
Coating	TiAlN
Tool material	Solid carbide
Version	12xD
Point angle	135 °
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 _c	ISO code
Steel < 500 N/mm ²	suitable	90 m/min	P
Steel < 750 N/mm ²	suitable	75 m/min	P
Steel < 900 N/mm ²	suitable	70 m/min	P
Steel < 1100 N/mm ²	suitable	55 m/min	P
Steel < 1400 N/mm ²	suitable	32 m/min	P
INOX < 900 N/mm ²	suitable	70 m/min	M
INOX > 900 N/mm ²	suitable	60 m/min	M

Uni	suitable
wet maximum	suitable
wet minimum	suitable