Garant

Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, ∅ DC h7: 5,51-Xmm

Order data

Order number	123115 5,51-X
GTIN	4062406523152
Item class	11E

Description

Version:
Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry.**
Particularly high alignment accuracy due to **4 guide chamfers** which stabilise the drill even at extreme depths!
Straight major cutting edges with honed edges and special flute profile for **short chips**, even on long chipping materials.
Advantage:
High process reliability and surface quality of the hole.
Note:
Flute length $L_C = L_2 + 1.5 \times D_C$. 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 ±10% (minimum 1 piece).

Technical description

Flute length L_c	70 mm
Feed f in stainless steel < 900 N/mm^2	0.12 mm/rev.
Shank tolerance	h6
Overall length L	110 mm
Number of cutting edges Z	2
Standard	Manufacturer’s standard

Ø range	5.51 mm
Tolerance nominal Ø	h7
Shank Ø D_s	6 mm
Coating	TiAlN
Tool material	Solid carbide
Version	10×D
Point angle	135 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_c**	**ISO code**
Aluminium (short chipping)	suitable only under restricted conditions	200 m/min	N
Alu > 10% Si	suitable only under restricted conditions	180 m/min	N
Steel < 500 N/mm^2	suitable	110 m/min	P
Steel < 750 N/mm^2	suitable	80 m/min	P
Steel < 900 N/mm^2	suitable	70 m/min	P
INOX < 900 N/mm^2	suitable	65 m/min	M
INOX > 900 N/mm^2	suitable	55 m/min	M
Ti > 850 N/mm^2	suitable	25 m/min	S
Uni	suitable only under restricted conditions		
wet maximum	suitable		
wet minimum	suitable		