

**Garant**
**Solid carbide HPC drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 14,06-Xmm**

**Order data**

|              |                |
|--------------|----------------|
| Order number | 122385 14,06-X |
| GTIN         | 4062406076894  |
| Item class   | 11E            |

**Description**
**Version:**

Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry**. **Straight major cutting edges** with slightly honed edges and special flute profile produce **short chips**.

**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  $\pm 10\%$  (minimum 1 piece).

**Technical description**

|   |                  |
|---|------------------|
| Standard  | DIN 6537 K       |
| Tolerance nominal $\varnothing$                   | h7               |
| Overall length L                                  | 115 mm           |
| Flute length $L_c$                                | 65 mm            |
| Feed f in stainless steel < 900 N/mm <sup>2</sup> | 0.18 mm/rev.     |
| Shank $\varnothing D_s$                           | 16 mm            |
| Number of cutting edges Z                         | 2                |
| $\varnothing$ range                               | 14.06 - 16.05 mm |

|                    |                   |
|--------------------|-------------------|
| Coating            | TiAlN             |
| Tool material      | Solid carbide     |
| Version            | 4xD               |
| 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 <sub>c</sub> | ISO code |
|--------------------------------|---|----------------|----------|
| Aluminium (short chipping)     | suitable only under restricted conditions | 245 m/min      | N        |
| Steel < 500 N/mm <sup>2</sup>  | suitable                                  | 110 m/min      | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable                                  | 90 m/min       | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable                                  | 85 m/min       | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable                                  | 60 m/min       | P        |
| Steel < 1400 N/mm <sup>2</sup> | suitable only under restricted conditions | 35 m/min       | P        |
| INOX < 900 N/mm <sup>2</sup>   | suitable                                  | 55 m/min       | M        |
| INOX > 900 N/mm <sup>2</sup>   | suitable                                  | 50 m/min       | M        |
| Ti > 850 N/mm <sup>2</sup>     | suitable                                  | 35 m/min       | S        |
| Uni                            | suitable                                  |                |          |
| wet maximum                    | suitable                                  |                |          |
| wet minimum                    | suitable                                  |                |          |
| Air                            | suitable                                  |                |          |

