

## Garant

### Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, Ø DC p6: 12,06-Xmm



#### Order data

Order number	122738 12,06-X
GTIN	4062406079499
Item class	11E

#### Description

##### 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. With **140° point angle** and special **j6 cutting edge tolerance** for optimum generation of a pilot hole.

##### Note:

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

For deep-hole drilling deeper than 12xD a pilot hole is recommended, and for deep-hole drilling from 20xD to 30xD it is essential.

**The generation of a pilot hole always improves process reliability.** 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

Tolerance nominal Ø	h7
Overall length L	124 mm
Number of cutting edges Z	2
Standard	DIN 6537

Shank $\varnothing D_s$	14 mm
Flute length $L_c$	77 mm
Feed $f$ in steel $< 1100 \text{ N/mm}^2$	0.27 mm/rev.
$\varnothing$ range	12.06 - 14.05 mm
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 $< 500 \text{ N/mm}^2$	suitable	170 m/min	P
Steel $< 750 \text{ N/mm}^2$	suitable	130 m/min	P
Steel $< 900 \text{ N/mm}^2$	suitable	120 m/min	P
Steel $< 1100 \text{ N/mm}^2$	suitable	110 m/min	P
Steel $< 1400 \text{ N/mm}^2$	suitable	65 m/min	P
INOX $< 900 \text{ N/mm}^2$	suitable	75 m/min	M
INOX $> 900 \text{ N/mm}^2$	suitable	70 m/min	M
GG(G)	suitable	95 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable		
Air	suitable		

