Garant

Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, Ø DC p6: 16,06-Xmm

Order data

Order number	122738 16,06-X
GTIN	4062406079512
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 12×D a pilot hole is recommended, and for deep-hole drilling from 20×D to 30×D 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

Standard	DIN 6537
Feed f in steel < 1100 N/mm^2	0.32 mm/rev.
Shank Ø D_s	18 mm
Flute length L_c	93 mm

Tolerance nominal ∅	h7
Number of cutting edges Z	2
Overall length L	143 mm
∅ range	16.06 - 18.05 mm
Coating	TiAlN
Tool material	Solid carbide
Version	6×D
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	170 m/min	P
Steel < 750 N/mm^2	suitable	130 m/min	P
Steel < 900 N/mm^2	suitable	120 m/min	P
Steel < 1100 N/mm^2	suitable	110 m/min	P
Steel < 1400 N/mm^2	suitable	65 m/min	P
INOX < 900 N/mm^2	suitable	75 m/min	M
INOX > 900 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		