

## Garant

### Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, Ø DC p6: 18,06-Xmm



## Order data

Order number	122738 18,06-X
GTIN	4062406079529
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

Flute length $L_c$	101 mm
Shank Ø $D_s$	20 mm
Feed $f$ in steel < 1100 N/mm <sup>2</sup>	0.37 mm/rev.
Overall length $L$	153 mm

Tolerance nominal $\varnothing$	h7
Number of cutting edges Z	2
Standard	DIN 6537
$\varnothing$ range	18.06 - 20.05 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 N/mm <sup>2</sup>	suitable	170 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	130 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	120 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	110 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	65 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	75 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	70 m/min	M
GG(G)	suitable	95 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable		
Air	suitable		

