Garant

Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, ∅ DC m6 (∅ DC X = h7): 1/4 mm

Order data

Order number	122661 1/4
GTIN	4062406120542
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 ∅ 3.8 mm. Up to 3.7 mm ∅ with 2 internal cooling channels. **Straight major cutting edges** with honed edges and special flute profile for **short chips**, even on long chipping materials.
Recommendation:
Maximum drilling depth:
Flute length (see table) less 1.5×nominal ∅.
Attention:
Sizes **ending with X** = cutter ∅ tolerance **h7.**
Note:
Flute length $L_C = L_2 + 1.5 \times D_C$.
Machining strategy: HPC
Standard: DIN 6537
Tolerance nominal ∅: m6
Number of cutting edges Z: 2
Semi-Standard: yes
Tolerance nominal ∅: m6
recommended maximum drilling depth L_2: 43.475 mm
Overall length L: 91 mm
Shank ∅ D_s: 8 mm
Feed f in stainless steel > 900 N/mm^2: 0.12 mm/rev.

Technical description

Tolerance nominal ∅	m6
Flute length L_c	53 mm
Inch nominal ∅ corresponds to	6.35 mm
recommended maximum drilling depth L_2	43.475 mm
Feed f in stainless steel > 900 N/mm^2	0.12 mm/rev.
Standard	DIN 6537
Number of cutting edges Z	2
Shank ∅ D_s	8 mm
Overall length L	91 mm
Semi-Standard	yes
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	6×D
Point angle	140 degrees
Shank	DIN 6535 HB to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Colour ring	blue
Type of product	Jobber drill