

**Garant**

**Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, Ø DC m6 (Ø DC X = h7): 5/32 mm**

**Order data**

Order number	122661 5/32
GTIN	4062406119874
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. **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 Ø.

**Attention:**

Sizes **ending with X** = cutter Ø tolerance **h7**.

**Note:**

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

Machining strategy: HPC

Standard: DIN 6537

Tolerance nominal Ø: m6

Number of cutting edges Z: 2

Semi-Standard: yes

Tolerance nominal Ø: m6

recommended maximum drilling depth  $L_2$ : 30.045 mm

Overall length L: 74 mm

Shank Ø  $D_s$ : 6 mm

Feed f in stainless steel > 900 N/mm<sup>2</sup>: 0.08 mm/rev.

**Technical description**

Tolerance nominal Ø	m6
recommended maximum drilling depth L <sub>2</sub>	30.045 mm
Overall length L	74 mm
Inch nominal Ø corresponds to	3.97 mm
Feed f in stainless steel > 900 N/mm <sup>2</sup>	0.08 mm/rev.
Flute length L <sub>c</sub>	36 mm
Standard	DIN 6537
Number of cutting edges Z	2
Shank Ø D <sub>s</sub>	6 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