

Garant
Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, Ø DC p6: 3,2 mm

Order data

Order number	122738 3,2
GTIN	4045197567499
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.

Recommendation:
Maximum drilling depth:

clamping slot length (see table) less 1.5×nominal Ø.

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.

Standard: DIN 6537

Tolerance nominal Ø: p6

Number of cutting edges Z: 2

Semi-Standard: yes

Tolerance nominal Ø: p6

recommended maximum drilling depth L_2 : 23.2 mm

Overall length L: 66 mm

Shank Ø D_s : 6 mm

Feed f in steel < 1100 N/mm²: 0.08 mm/rev.

Technical description

Nominal Ø D_c	3.2 mm
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Shank tolerance	h6
Number of cutting edges Z	2
Feed f in steel < 1100 N/mm ²	0.08 mm/rev.
Flute length L _c	28 mm
Tolerance nominal Ø	p6
Shank Ø D _s	6 mm
Overall length L	66 mm
Standard	DIN 6537
recommended maximum drilling depth L ₂	23.2 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	green
Type of product	Jobber drill