

**Garant**
**Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, Ø DC m6: 3/16 mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 123010 3/16   |
| GTIN         | 4062406120948 |
| 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:**

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

**Note:**

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

Standard: Manufacturer's standard

Tolerance nominal Ø: m6

Number of cutting edges Z: 2

Tolerance nominal Ø: m6

recommended maximum drilling depth  $L_2$ : 49.86 mm

Overall length L: 95 mm

Shank Ø  $D_s$ : 6 mm

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

**Technical description**

|                                                   |                         |
|---------------------------------------------------|-------------------------|
| Feed f in stainless steel > 900 N/mm <sup>2</sup> | 0.08 mm/rev.            |
| Inch nominal Ø corresponds to                     | 4.76 mm                 |
| Standard                                          | Manufacturer's standard |
| recommended maximum drilling depth $L_2$          | 49.86 mm                |

|                             |                   |
|-----------------------------|-------------------|
| Tolerance nominal Ø         | m6                |
| Overall length L            | 95 mm             |
| Number of cutting edges Z   | 2                 |
| Shank Ø D <sub>s</sub>      | 6 mm              |
| Flute length L <sub>c</sub> | 57 mm             |
| Coating                     | TiAlN             |
| Tool material               | Solid carbide     |
| Drill depth up to           | 8xD               |
| Point angle                 | 140 degrees       |
| Cutting direction           | right-hand        |
| Shank                       | DIN 6535 HB to h6 |
| Through-coolant             | yes, with 25 bar  |
| Machining strategy          | HPC               |
| Semi-Standard               | yes               |
| Colour ring                 | blue              |
| Type of product             | Jobber drill      |