

**Garant**
**Solid carbide HPC drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 13,5 mm**

**Order data**

Order number	122385 13,5
GTIN	4045197389183
Item class	11E

**Description**
**Version:**

Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry**. **Straight major cutting edges** with slightly honed edges and special flute profile produce **short chips**.

**Recommendation:**
**Maximum drilling depth:**

Flute length (see table) less 1.5×nominal Ø.

**Note:**

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

Standard: DIN 6537 K

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

Tolerance nominal Ø: h7

recommended maximum drilling depth  $L_2$ : 39.8 mm

Overall length L: 107 mm

Shank Ø  $D_s$ : 14 mm

Feed f in stainless steel < 900 N/mm<sup>2</sup>: 0.18 mm/rev.

**Technical description**

Flute length $L_c$	60 mm
Number of cutting edges Z	2
Shank tolerance	h6
Feed f in stainless steel < 900 N/mm <sup>2</sup>	0.18 mm/rev.
Nominal Ø $D_c$	13.5 mm

Tolerance nominal $\varnothing$	h7
Shank $\varnothing D_s$	14 mm
Overall length L	107 mm
Standard	DIN 6537 K
recommended maximum drilling depth $L_2$	39.8 mm
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	4xD
Point angle	135 degrees
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