

Garant
Solid carbide HPC drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 13,8 mm

Order data

Order number	122385 13,8
GTIN	4045197389190
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 : 39.3 mm

Overall length L: 107 mm

Shank Ø D_s : 14 mm

Feed f in stainless steel < 900 N/mm²: 0.18 mm/rev.

Technical description

Number of cutting edges Z	2
Flute length L_c	60 mm
Feed f in stainless steel < 900 N/mm ²	0.18 mm/rev.
Shank tolerance	h6
Nominal Ø D_c	13.8 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	39.3 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