

**Garant**
**Solid carbide HPC drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 6,8 mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 122385 6,8    |
| GTIN         | 4045197388957 |
| 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  $L_2$ : 23.8 mm

Overall length L: 79 mm

Shank Ø  $D_s$ : 8 mm

Feed f in stainless steel < 900 N/mm<sup>2</sup>: 0.12 mm/rev.

**Technical description**

|   |              |
|---|--------------|
| Feed f in stainless steel < 900 N/mm <sup>2</sup> | 0.12 mm/rev. |
| Nominal Ø $D_c$                                   | 6.8 mm       |
| Number of cutting edges Z                         | 2            |
| Shank tolerance                                   | h6           |
| Flute length $L_c$                                | 34 mm        |

|  |                   |
|--|-------------------|
| Tolerance nominal $\varnothing$          | h7                |
| Shank $\varnothing D_s$                  | 8 mm              |
| Overall length L                         | 79 mm             |
| Standard                                 | DIN 6537 K        |
| recommended maximum drilling depth $L_2$ | 23.8 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      |