

**Garant**
**Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, Ø DC m6: 18 mm**

**Order data**

Order number	122432 18
GTIN	4045197540164
Item class	11E

**Description**
**Version:**

Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry**. Excellent chip evacuation due to **4 internal coolant channels**. **Straight cutting edges** with honed edges and special flute profile for **short chips**. **Special coating** for the **best tool life** and **high metal removal rates**.

**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: m6

Number of cutting edges Z: 2

Semi-Standard: yes

Tolerance nominal Ø: m6

recommended maximum drilling depth  $L_2$ : 46 mm

Overall length L: 123 mm

Shank Ø  $D_s$ : 18 mm

Feed f in Inconel®: 0.2 mm/rev.

**Technical description**

Feed f in Inconel®	0.2 mm/rev.
Number of cutting edges Z	2
Nominal Ø $D_c$	18 mm
Shank tolerance	h6

Flute length $L_c$	73 mm
Tolerance nominal $\varnothing$	m6
Shank $\varnothing D_s$	18 mm
Overall length L	123 mm
Standard	DIN 6537 K
recommended maximum drilling depth $L_2$	46 mm
Semi-Standard	yes
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	4×D
Point angle	140 degrees
Shank	DIN 6535 HB to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Colour ring	pink
Type of product	Jobber drill