

**Garant**
**Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, Ø DC m6: 6,6 mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 122432 6,6    |
| GTIN         | 4045197539564 |
| 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

Tolerance nominal Ø: m6

recommended maximum drilling depth  $L_2$ : 24.1 mm

Overall length L: 79 mm

Shank Ø  $D_s$ : 8 mm

Feed f in Inconel®: 0.08 mm/rev.

**Technical description**

|                           |              |
|---------------------------|--------------|
| Shank tolerance           | h6           |
| Number of cutting edges Z | 2            |
| Nominal Ø $D_c$           | 6.6 mm       |
| Feed f in Inconel®        | 0.08 mm/rev. |

|  |                   |
|--|-------------------|
| Flute length $L_c$                       | 34 mm             |
| Tolerance nominal $\varnothing$          | m6                |
| Shank $\varnothing D_s$                  | 8 mm              |
| Overall length L                         | 79 mm             |
| Standard                                 | DIN 6537 K        |
| recommended maximum drilling depth $L_2$ | 24.1 mm           |
| Coating                                  | TiAlN             |
| Tool material                            | Solid carbide     |
| Drill depth up to                        | 4xD               |
| Point angle                              | 140 degrees       |
| Shank                                    | DIN 6535 HB to h6 |
| Through-coolant                          | yes, with 25 bar  |
| Machining strategy                       | HPC               |
| Semi-Standard                            | yes               |
| Colour ring                              | pink              |
| Type of product                          | Jobber drill      |