

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

**Order data**

Order number	122603 13,8
GTIN	4045197758354
Item class	11E

**Description**
**Version:**

**DLC coating  $sp^2$**  of the latest generation with **low coefficient of friction** results in **outstanding chip clearance**. For **high-performance milling** of **aluminium materials**. **High roundness** and **alignment accuracy of the deep hole**, thanks to **6 guide chamfers**.

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

clamping slot length (see table) less  $1.5 \times$  nominal  $\varnothing$ .

**Note:**

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

Standard: DIN 6537

Tolerance nominal  $\varnothing$ : h7

Number of cutting edges Z: 2

Tolerance nominal  $\varnothing$ : h7

recommended maximum drilling depth  $L_2$ : 56.3 mm

Overall length L: 124 mm

Shank  $\varnothing D_s$ : 14 mm

Feed f in aluminium short-chipping: 0.65 mm/rev.

**Technical description**

Shank $\varnothing D_s$	14 mm
Overall length L	124 mm
Nominal $\varnothing D_c$	13.8 mm
Flute length $L_c$	77 mm
Standard	DIN 6537

Tolerance nominal $\varnothing$	h7
Shank tolerance	h6
Feed f in aluminium short-chipping	0.65 mm/rev.
Number of cutting edges Z	2
recommended maximum drilling depth L <sub>2</sub>	56.3 mm
Coating	DLC
Tool material	solid carbide
Drill depth up to	6×D
Type	W
Point angle	135 degrees
Shank	DIN 6535 HB to h6
Through-coolant	Yes, with 25 bar
Machining strategy	HPC
Semi-Standard	yes
Colour ring	yellow
Type of product	Jobber drill