

**Garant**
**Solid carbide HPC drill Weldon shank DIN 6535 HB, DLC, Ø DC h7: 6,9 mm**

**Order data**

Order number	122603 6,9
GTIN	4045197757883
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  $L_2$ : 42.7 mm

Overall length L: 91 mm

Shank  $\varnothing D_s$ : 8 mm

Feed f in aluminium short-chipping: 0.45 mm/rev.

**Technical description**

Nominal $\varnothing D_c$	6.9 mm
Flute length $L_c$	53 mm
Number of cutting edges Z	2
Shank $\varnothing D_s$	8 mm
Feed f in aluminium short-chipping	0.45 mm/rev.

Standard	DIN 6537
Tolerance nominal $\varnothing$	h7
Shank tolerance	h6
Overall length L	91 mm
recommended maximum drilling depth L <sub>2</sub>	42.7 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