

**Garant**
**Solid carbide HPC drill Weldon shank DIN 6535 HB, DLC, Ø DC p6: 12 mm**

**Order data**

Order number	122608 12
GTIN	4045197569028
Item class	11E

**Description**
**Version:**

Spiral fluted, with **6 guide chamfers** and internal cooling channels.

New generation of high performance pilot drills in the HPC range.

With **140° point angle** and special **p6 cutting edge tolerance** for optimum generation of a pilot hole. High alignment accuracy and **roundness of the pilot hole**.

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

clamping slot length (see table) less 1.5×nominal Ø.

**Note:**

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

For deep-hole drilling deeper than 16×D a pilot hole is recommended, and for deep-hole drilling from 20×D to 30×D it is essential. **The generation of a pilot hole always improves process reliability.**

Standard: DIN 6537

Tolerance nominal Ø: p6

Number of cutting edges Z: 2

Tolerance nominal Ø: p6

recommended maximum drilling depth  $L_2$ : 53 mm

Overall length L: 118 mm

Shank Ø  $D_s$ : 12 mm

Feed f in aluminium short-chipping: 0.44 mm/rev.

**Technical description**

Nominal Ø $D_c$	12 mm
Shank tolerance	h6
Flute length $L_c$	71 mm

Feed f in aluminium short-chipping	0.44 mm/rev.
Number of cutting edges Z	2
Tolerance nominal $\varnothing$	p6
Shank $\varnothing D_s$	12 mm
Overall length L	118 mm
Standard	DIN 6537
recommended maximum drilling depth L <sub>2</sub>	53 mm
Coating	DLC
Tool material	Solid carbide
Drill depth up to	6×D
Type	W
Point angle	140 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