

Garant
Solid carbide HPC drill Weldon shank DIN 6535 HB, DLC, Ø DC p6: 6,8 mm

Order data

Order number	122608 6,8
GTIN	4045197568854
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 : 42.8 mm

Overall length L: 91 mm

Shank Ø D_s : 8 mm

Feed f in aluminium short-chipping: 0.36 mm/rev.

Technical description

Number of cutting edges Z	2
Shank tolerance	h6
Nominal Ø D_c	6.8 mm

Feed f in aluminium short-chipping	0.36 mm/rev.
Flute length L _c	53 mm
Tolerance nominal Ø	p6
Shank Ø D _s	8 mm
Overall length L	91 mm
Standard	DIN 6537
recommended maximum drilling depth L ₂	42.8 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