Hoffmann Group

Garant

Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, Ø DC m6 (Ø DC X = h7): 14,2 mm

Order data

Order number	122661 14,2
GTIN	4045197458056
Item class	11E

Description

Version:
Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry.** High roundness and alignment accuracy of the deep hole, thanks to **4 guide chamfers.** Outstanding chip evacuation due to **4 internal cooling channels** from Ø 3.8 mm. Up to 3.7 mm Ø with 2 internal cooling channels. **Straight major cutting edges** with honed edges and special flute profile for **short chips**, even on long chipping materials.
Recommendation:
Maximum drilling depth:
Flute length (see table) less 1.5×nominal Ø.
Attention:
Sizes **ending with X** = cutter Ø tolerance **h7.**
Note:
Flute length $L_c = L_2 + 1.5 \times D_C$.
Standard: DIN 6537
Tolerance nominal Ø: m6
Number of cutting edges Z: 2
Tolerance nominal Ø: m6
recommended maximum drilling depth L_2: 61.7 mm
Overall length L: 133 mm
Shank Ø D_s: 16 mm
Feed f in stainless steel > 900 N/mm^2: 0.2 mm/rev.

Technical description

Flute length L_c	83 mm
Nominal Ø D_C	14.2 mm

Feed f in stainless steel > 900 N/mm^2	0.2 mm/rev.
Number of cutting edges Z	2
Shank tolerance	h6
Tolerance nominal Ø	m6
Shank Ø D$_s$	16 mm
Overall length L	133 mm
Standard	DIN 6537
recommended maximum drilling depth L$_2$	61.7 mm
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	6×D
Point angle	140 degrees
Cutting direction	right-hand
Shank	DIN 6535 HB to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Semi-Standard	yes
Colour ring	blue
Type of product	Jobber drill