

Garant

Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, Ø DC m6 (Ø DC X = h7): 18,85 mm



Order data

Order number	122661 18,85
GTIN	4045197745477
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 : 72.8 mm

Overall length L: 153 mm

Shank Ø D_s : 20 mm

Feed f in stainless steel > 900 N/mm²: 0.25 mm/rev.

Technical description

Nominal Ø D_c	18.85 mm
Number of cutting edges Z	2

Feed f in stainless steel > 900 N/mm ²	0.25 mm/rev.
Tolerance nominal Ø	m6
Shank tolerance	h6
Overall length L	153 mm
Shank Ø D _s	20 mm
Flute length L _c	101 mm
Standard	DIN 6537
recommended maximum drilling depth L ₂	72.8 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