Garant

# Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, ∅ DC m6 (∅ DC X = h7): 19 mm

## Order data

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|---|---|
| Order number | 122661 19 |
| GTIN | 4045197458209 |
| 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 ∅ 3.8 mm. Up to 3.7 mm ∅ 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 ∅.
**Attention:**
Sizes **ending with X** = cutter ∅ tolerance **h7.**
**Note:**
Flute length $L_C = L_2 + 1.5 \times D_C$.
Standard: DIN 6537
Tolerance nominal ∅: m6
Number of cutting edges Z: 2
Tolerance nominal ∅: m6
recommended maximum drilling depth $L_2$: 72.5 mm
Overall length L: 153 mm
Shank ∅ $D_s$: 20 mm
Feed f in stainless steel > 900 N/mm$^2$: 0.25 mm/rev.

## Technical description

| | |
|---|---|
| Flute length $L_c$ | 101 mm |
| Feed f in stainless steel > 900 N/mm$^2$ | 0.25 mm/rev. |

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|---|---|
| Nominal ⌀ $D_C$ | 19 mm |
| Shank tolerance | h6 |
| Number of cutting edges Z | 2 |
| Tolerance nominal ⌀ | m6 |
| Shank ⌀ $D_s$ | 20 mm |
| Overall length L | 153 mm |
| Standard | DIN 6537 |
| recommended maximum drilling depth $L_2$ | 72.5 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 |