

# Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, $\varnothing$ DC m6 ( $\varnothing$ DC X = h7): 6,1 mm



### **Order data**

Order number	122661 6,1
GTIN	4045197457493
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  $1.5 \times \text{nominal } \emptyset$ .

#### Attention:

Sizes **ending with X** = cutter  $\emptyset$  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<sub>2</sub>: 43.9 mm

Overall length L: 91 mm

Shank Ø D<sub>s</sub>: 8 mm

Feed f in stainless steel > 900 N/mm<sup>2</sup>: 0.12 mm/rev.

# **Technical description**

Flute length L <sub>c</sub>	53 mm
Feed f in stainless steel > 900 N/mm <sup>2</sup>	0.12 mm/rev.

Shank tolerance       h6         Tolerance nominal Ø       m6         Shank Ø D₅       8 mm         Overall length L       91 mm         Standard       DIN 6537         recommended maximum drilling depth L₂       43.9 mm         Coating       TiAIN         Tool material       Solid carbide         Drill depth up to       6xD         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	Number of cutting edges Z	2
Tolerance nominal Ø m6  Shank Ø D <sub>s</sub> 8 mm  Overall length L 91 mm  Standard DIN 6537  recommended maximum drilling depth L <sub>2</sub> 43.9 mm  Coating TiAIN  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	Nominal Ø D <sub>c</sub>	6.1 mm
Shank Ø D₃  Overall length L  Standard  DIN 6537  recommended maximum drilling depth L₂  Coating  TiAIN  Tool material  Solid carbide  Drill depth up to  Foint angle  Cutting direction  Shank  DIN 6535 HB to h6  Through-coolant  Machining strategy  HPC  Semi-Standard  Coverall length L₂  43.9 mm  Solid carbide  6×D  6×D  140 degrees  140 degrees  140 degrees  HPC  Semi-Standard  yes, with 25 bar  HPC  Semi-Standard  yes  Colour ring	Shank tolerance	h6
Overall length L91 mmStandardDIN 6537recommended maximum drilling depth L₂43.9 mmCoatingTiAINTool materialSolid carbideDrill depth up to6×DPoint angle140 degreesCutting directionright-handShankDIN 6535 HB to h6Through-coolantyes, with 25 barMachining strategyHPCSemi-StandardyesColour ringblue	Tolerance nominal Ø	m6
Standard  DIN 6537  recommended maximum drilling depth L2  43.9 mm  TiAIN  Tool material  Solid carbide  Drill depth up to  6×D  Point angle  Cutting direction  Shank  DIN 6535 HB to h6  Through-coolant  Machining strategy  HPC  Semi-Standard  Colour ring  DIN 6537  43.9 mm  A3.9 mm  TiAIN  Tool material  Solid carbide  6×D  140 degrees  right-hand  DIN 6535 HB to h6  Yes, with 25 bar  HPC  Semi-Standard  yes  Colour ring  blue	Shank Ø D <sub>s</sub>	8 mm
recommended maximum drilling depth L2 43.9 mm  Coating TiAIN  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	Overall length L	91 mm
Coating TiAIN  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	Standard	DIN 6537
Tool material  Drill depth up to  Point angle  Cutting direction  Shank  DIN 6535 HB to h6  Through-coolant  Machining strategy  HPC  Semi-Standard  Colour ring  Solid carbide  6×D  140 degrees  140 degrees  right-hand  yes, with 25 bar  HPC  yes  blue	recommended maximum drilling depth L <sub>2</sub>	43.9 mm
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	Coating	TiAIN
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	Tool material	Solid carbide
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	Drill depth up to	6×D
Shank  DIN 6535 HB to h6  Through-coolant  Machining strategy  HPC  Semi-Standard  yes  blue	Point angle	140 degrees
Through-coolant yes, with 25 bar  Machining strategy HPC  Semi-Standard yes  Colour ring blue	Cutting direction	right-hand
Machining strategy HPC Semi-Standard yes Colour ring blue	Shank	DIN 6535 HB to h6
Semi-Standard yes Colour ring blue	Through-coolant	yes, with 25 bar
Colour ring blue	Machining strategy	HPC
<b>3</b>	Semi-Standard	yes
Type of product Jobber drill	Colour ring	blue
	Type of product	Jobber drill