

## Garant

**Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, Ø DC m6 (Ø DC X = h7): 7,25 mm**



### Order data

|              |               |
|--------------|---------------|
| Order number | 122661 7,25   |
| GTIN         | 4045197583307 |
| 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  $L_2$ : 42.2 mm

Overall length L: 91 mm

Shank Ø  $D_s$ : 8 mm

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

### Technical description

|   |              |
|---|--------------|
| Feed f in stainless steel > 900 N/mm <sup>2</sup> | 0.12 mm/rev. |
| Nominal Ø $D_c$                                   | 7.25 mm      |

|   |                   |
|---|-------------------|
| Number of cutting edges Z                         | 2                 |
| Shank tolerance                                   | h6                |
| Flute length L <sub>c</sub>                       | 53 mm             |
| 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> | 42.2 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      |