

## Garant

**Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, Ø DC m6 (Ø DC X = h7): 8,4 mm**



### Order data

Order number	122661 8,4
GTIN	4045197457721
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  $L_c = L_2 + 1.5 \times D_c$ .

Machining strategy: HPC

Standard: DIN 6537

Tolerance nominal Ø: m6

Number of cutting edges Z: 2

Semi-Standard: yes

Tolerance nominal Ø: m6

recommended maximum drilling depth  $L_2$ : 48.4 mm

Overall length L: 103 mm

Shank Ø  $D_s$ : 10 mm

Feed f in stainless steel > 900 N/mm<sup>2</sup>: 0.15 mm/rev.

### Technical description

Feed f in stainless steel > 900 N/mm <sup>2</sup>	0.15 mm/rev.
Shank tolerance	h6
Flute length L <sub>c</sub>	61 mm
Nominal Ø D <sub>c</sub>	8.4 mm
Number of cutting edges Z	2
Tolerance nominal Ø	m6
Shank Ø D <sub>s</sub>	10 mm
Overall length L	103 mm
Standard	DIN 6537
recommended maximum drilling depth L <sub>2</sub>	48.4 mm
Semi-Standard	yes
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	6×D
Point angle	140 degrees
Shank	DIN 6535 HB to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Colour ring	blue
Type of product	Jobber drill