

## Garant

### Solid carbide HPC drill type FS Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 6,8 mm



#### Order data

Order number	122675 6,8
GTIN	4045197398024
Item class	11E

#### Description

##### Version:

**Particularly strong** due to strengthened core and **special profile**. Special point geometry.

**High concentricity** and **long tool life**.

**Precision drilling qualities.**

##### Recommendation:

##### Maximum drilling depth:

Flute length (see table) less 1.5×nominal Ø.

##### Note:

Flute length  $L_c = L_2 + 1.5 \times D_c$ .

Standard: DIN 6537

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

Tolerance nominal Ø: h7

recommended maximum drilling depth  $L_2$ : 42.8 mm

Overall length L: 91 mm

Shank Ø  $D_s$ : 8 mm

Feed f in titanium > 850 N/mm<sup>2</sup>: 0.08 mm/rev.

#### Technical description

Number of cutting edges Z	2
Feed f in titanium > 850 N/mm <sup>2</sup>	0.08 mm/rev.
Flute length $L_c$	53 mm
Shank tolerance	h6

Nominal $\varnothing D_c$	6.8 mm
Tolerance nominal $\varnothing$	h7
Shank $\varnothing D_s$	8 mm
Overall length L	91 mm
Standard	DIN 6537
recommended maximum drilling depth $L_2$	42.8 mm
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	6xD
Type	FS
Point angle	140 degrees
Shank	DIN 6535 HB to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Semi-Standard	yes
Colour ring	pink
Type of product	Jobber drill