

Garant

Solid carbide HPC drill type FS Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 8,4 mm



Order data

Order number	122675 8,4
GTIN	4045197398185
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

Semi-Standard: yes

Tolerance nominal Ø: h7

recommended maximum drilling depth L_2 : 48.4 mm

Overall length L: 103 mm

Shank Ø D_s : 10 mm

Feed f in titanium > 850 N/mm²: 0.12 mm/rev.

Technical description

Nominal Ø D_c	8.4 mm
Flute length L_c	61 mm
Number of cutting edges Z	2
Shank tolerance	h6

Feed f in titanium > 850 N/mm ²	0.12 mm/rev.
Tolerance nominal Ø	h7
Shank Ø D _s	10 mm
Overall length L	103 mm
Standard	DIN 6537
recommended maximum drilling depth L ₂	48.4 mm
Semi-Standard	yes
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	6×D
Type	FS
Point angle	140 degrees
Shank	DIN 6535 HB to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Colour ring	pink
Type of product	Jobber drill