# Garant

### Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAIN, Ø DC p6: 13 mm



## Order data

Order number	122738 13
GTIN	4045197567857
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. With **140° point angle** and special **j6 cutting edge tolerance** for optimum generation of a pilot hole.

#### **Recommendation:**

#### Maximum drilling depth:

clamping slot length (see table) less  $1.5 \times nominal \emptyset$ .

#### Note:

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

For deep-hole drilling deeper than  $12 \times D$  a pilot hole is recommended, and for deep-hole drilling from  $20 \times D$  to  $30 \times D$  it is essential.

### The generation of a pilot hole always improves process reliability.

Standard: DIN 6537 Tolerance nominal Ø: p6 Number of cutting edges Z: 2 Tolerance nominal Ø: p6 recommended maximum drilling depth L<sub>2</sub>: 57.5 mm Overall length L: 124 mm Shank Ø D<sub>s</sub>: 14 mm Feed f in steel < 1100 N/mm<sup>2</sup>: 0.32 mm/rev.

## **Technical description**

Feed f in steel < 1100 N/mm <sup>2</sup>	0.32 mm/rev.
Number of cutting edges Z	2

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Flute length L77 mmTolerance nominal Øp6Shank Ø Ds14 mmOverall length L124 mmStandardDIN 6537recommended maximum drilling depth L257.5 mmCoatingTiAINTool materialSolid carbideDrill depth up to6×DPoint angle140 degreesShankDIN 6535 HB to h6Through-coolantyes, with 25 barMachining strategyHPCSemi-Standardyes	Shank tolerance	h6
Tolerance nominal Øp6Shank Ø Ds14 mmOverall length L124 mmStandardDIN 6537recommended maximum drilling depth L257.5 mmCoatingTiAINTool materialSolid carbideDrill depth up to6×DPoint angle140 degreesShankDIN 6535 HB to h6Through-coolantyes, with 25 barMachining strategyHPCSemi-Standardyes	Nominal Ø D <sub>c</sub>	13 mm
Shank Ø Ds14 mmOverall length L124 mmStandardDIN 6537recommended maximum drilling depth L257.5 mmCoatingTiAINTool materialSolid carbideDrill depth up to6×DPoint angle140 degreesShankDIN 6535 HB to h6Through-coolantyes, with 25 barMachining strategyHPCSemi-Standardyes	Flute length L <sub>c</sub>	77 mm
Overall length L124 mmStandardDIN 6537recommended maximum drilling depth L257.5 mmCoatingTiAINTool materialSolid carbideDrill depth up to6×DPoint angle140 degreesShankDIN 6535 HB to h6Through-coolantyes, with 25 barMachining strategyHPCSemi-Standardyes	Tolerance nominal Ø	рб
StandardDIN 6537recommended maximum drilling depth L257.5 mmCoatingTiAINTool materialSolid carbideDrill depth up to6×DPoint angle140 degreesShankDIN 6535 HB to h6Through-coolantyes, with 25 barMachining strategyHPCSemi-Standardyes	Shank Ø D <sub>s</sub>	14 mm
recommended maximum drilling depth L <sub>2</sub> 57.5 mm 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 Semi-Standard yes	Overall length L	124 mm
CoatingTiAINTool materialSolid carbideDrill depth up to $6 \times D$ Point angle140 degreesShankDIN 6535 HB to h6Through-coolantyes, with 25 barMachining strategyHPCSemi-Standardyes	Standard	DIN 6537
Tool materialSolid carbideDrill depth up to6×DPoint angle140 degreesShankDIN 6535 HB to h6Through-coolantyes, with 25 barMachining strategyHPCSemi-Standardyes	recommended maximum drilling depth $L_2$	57.5 mm
Drill depth up to6×DPoint angle140 degreesShankDIN 6535 HB to h6Through-coolantyes, with 25 barMachining strategyHPCSemi-Standardyes	Coating	TiAIN
Point angle140 degreesShankDIN 6535 HB to h6Through-coolantyes, with 25 barMachining strategyHPCSemi-Standardyes	Tool material	Solid carbide
ShankDIN 6535 HB to h6Through-coolantyes, with 25 barMachining strategyHPCSemi-Standardyes	Drill depth up to	6×D
Through-coolantyes, with 25 barMachining strategyHPCSemi-Standardyes	Point angle	140 degrees
Machining strategyHPCSemi-Standardyes	Shank	DIN 6535 HB to h6
Semi-Standard yes	Through-coolant	yes, with 25 bar
	Machining strategy	HPC
	Semi-Standard	yes
Colour ring green	Colour ring	green
Type of product Jobber drill	Type of product	Jobber drill