Garant

# Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, ∅ DC p6: 3,8 mm

## Order data

| | |
|---|---|
| Order number | 122738 3,8 |
| GTIN | 4045197567543 |
| 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 ∅ 3.8 mm. Up to 3.7 mm ∅ 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×nominal ∅.
**Note:**
Flute length $L_C = L_2 + 1.5 \times D_C$.
For deep-hole drilling deeper than 12×D a pilot hole is recommended, and for deep-hole drilling from 20×D to 30×D it is essential.
**The generation of a pilot hole always improves process reliability.**
Standard: DIN 6537
Tolerance nominal ∅: p6
Number of cutting edges Z: 2
Tolerance nominal ∅: p6
recommended maximum drilling depth $L_2$: 30.3 mm
Overall length L: 74 mm
Shank ∅ $D_s$: 6 mm
Feed f in steel < 1100 N/mm$^2$: 0.08 mm/rev.

## Technical description

| | |
|---|---|
| Shank tolerance | h6 |
| Number of cutting edges Z | 2 |

| | |
|---|---|
| Flute length $L_c$ | 36 mm |
| Feed f in steel < 1100 N/mm$^2$ | 0.08 mm/rev. |
| Nominal ⌀ $D_C$ | 3.8 mm |
| Tolerance nominal ⌀ | p6 |
| Shank ⌀ $D_s$ | 6 mm |
| Overall length L | 74 mm |
| Standard | DIN 6537 |
| recommended maximum drilling depth $L_2$ | 30.3 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 |
| Colour ring | green |
| Type of product | Jobber drill |