

## Garant

### Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, Ø DC p6: 7,5 mm



## Order data

|              |               |
|--------------|---------------|
| Order number | 122738 7,5    |
| GTIN         | 4045197567680 |
| 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×nominal Ø.

#### 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 Ø: p6

Number of cutting edges Z: 2

Tolerance nominal Ø: p6

recommended maximum drilling depth  $L_2$ : 41.8 mm

Overall length L: 91 mm

Shank Ø  $D_s$ : 8 mm

Feed f in steel < 1100 N/mm<sup>2</sup>: 0.21 mm/rev.

## Technical description

|  |              |
|--|--------------|
| Feed f in steel < 1100 N/mm <sup>2</sup> | 0.21 mm/rev. |
| Shank tolerance                          | h6           |

|   |                   |
|---|-------------------|
| Number of cutting edges Z                         | 2                 |
| Flute length L <sub>c</sub>                       | 53 mm             |
| Nominal Ø D <sub>c</sub>                          | 7.5 mm            |
| Tolerance nominal Ø                               | p6                |
| Shank Ø D <sub>s</sub>                            | 8 mm              |
| Overall length L                                  | 91 mm             |
| Standard  | DIN 6537          |
| recommended maximum drilling depth L <sub>2</sub> | 41.8 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      |