

Garant

Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, Ø DC p6: 8,5 mm



Order data

Order number	122738 8,5
GTIN	4045197567727
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 : 48.3 mm

Overall length L: 103 mm

Shank Ø D_s : 10 mm

Feed f in steel < 1100 N/mm²: 0.27 mm/rev.

Technical description

Shank tolerance	h6
Flute length L_c	61 mm

Feed f in steel < 1100 N/mm ²	0.27 mm/rev.
Nominal Ø D _c	8.5 mm
Number of cutting edges Z	2
Tolerance nominal Ø	p6
Shank Ø D _s	10 mm
Overall length L	103 mm
Standard	DIN 6537
recommended maximum drilling depth L ₂	48.3 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