

## Garant

### Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, Ø DC m6: 11,8 mm



#### Order data

Order number	123010 11,8
GTIN	4045197572707
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. **Straight major cutting edges** with honed edges and special flute profile for **short chips**, even on long chipping materials.

##### Recommendation:

##### Maximum drilling depth:

clamping slot length (see table) less 1.5×nominal Ø.

##### Note:

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

Standard: Manufacturer's standard

Tolerance nominal Ø: m6

Number of cutting edges Z: 2

Tolerance nominal Ø: m6

recommended maximum drilling depth  $L_2$ : 96.3 mm

Overall length L: 162 mm

Shank Ø  $D_s$ : 12 mm

Feed f in stainless steel > 900 N/mm<sup>2</sup>: 0.15 mm/rev.

#### Technical description

Nominal Ø $D_c$	11.8 mm
Feed f in stainless steel > 900 N/mm <sup>2</sup>	0.15 mm/rev.
Number of cutting edges Z	2
Shank tolerance	h6

Flute length $L_c$	114 mm
Tolerance nominal $\varnothing$	m6
Shank $\varnothing D_s$	12 mm
Overall length L	162 mm
Standard	Manufacturer's standard
recommended maximum drilling depth $L_2$	96.3 mm
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	8xD
Point angle	140 degrees
Cutting direction	right-hand
Shank	DIN 6535 HB to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Semi-Standard	yes
Colour ring	blue
Type of product	Jobber drill