

## Garant

### Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, Ø DC m6: 15 mm



#### Order data

Order number	123010 15
GTIN	4045197572820
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  $L_2$ : 129.5 mm

Overall length L: 203 mm

Shank Ø  $D_s$ : 16 mm

Feed f in stainless steel > 900 N/mm<sup>2</sup>: 0.2 mm/rev.

#### Technical description

Shank tolerance	h6
Nominal Ø $D_c$	15 mm
Number of cutting edges Z	2
Flute length $L_c$	152 mm

Feed f in stainless steel > 900 N/mm <sup>2</sup>	0.2 mm/rev.
Tolerance nominal Ø	m6
Shank Ø D <sub>s</sub>	16 mm
Overall length L	203 mm
Standard	Manufacturer's standard
recommended maximum drilling depth L <sub>2</sub>	129.5 mm
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	8×D
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