

Garant

Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, Ø DC m6: 18,5 mm



Order data

Order number	123010 18,5
GTIN	4045197572929
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 $1.5 \times \text{nominal } \varnothing$.

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 : 162.3 mm

Overall length L: 243 mm

Shank Ø D_s : 20 mm

Feed f in stainless steel $> 900 \text{ N/mm}^2$: 0.25 mm/rev.

Technical description

Flute length L_c	190 mm
Nominal Ø D_c	18.5 mm
Feed f in stainless steel $> 900 \text{ N/mm}^2$	0.25 mm/rev.
Shank tolerance	h6

Number of cutting edges Z	2
Tolerance nominal \varnothing	m6
Shank $\varnothing D_s$	20 mm
Overall length L	243 mm
Standard	Manufacturer's standard
recommended maximum drilling depth L_2	162.3 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