

## Garant

### Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, Ø DC m6: 5,1 mm



#### Order data

Order number	123010 5,1
GTIN	4045197572158
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  $L_c = L_2 + 1.5 \times D_c$ .

Machining strategy: HPC

Standard: Manufacturer's standard

Tolerance nominal Ø: m6

Number of cutting edges Z: 2

Semi-Standard: yes

Tolerance nominal Ø: m6

recommended maximum drilling depth  $L_2$ : 49.4 mm

Overall length L: 95 mm

Shank Ø  $D_s$ : 6 mm

Feed f in stainless steel > 900 N/mm<sup>2</sup>: 0.12 mm/rev.

#### Technical description

Feed f in stainless steel > 900 N/mm <sup>2</sup>	0.12 mm/rev.
Number of cutting edges Z	2

Nominal $\varnothing D_c$	5.1 mm
Flute length $L_c$	57 mm
Shank tolerance	h6
Tolerance nominal $\varnothing$	m6
Shank $\varnothing D_s$	6 mm
Overall length L	95 mm
Standard	Manufacturer's standard
recommended maximum drilling depth $L_2$	49.4 mm
Semi-Standard	yes
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	8xD
Point angle	140 degrees
Shank	DIN 6535 HB to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Colour ring	blue
Type of product	Jobber drill