

Garant

Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, Ø DC m6: 7,7 mm



Order data

| | |
|--------------|---------------|
| Order number | 123010 7,7 |
| GTIN | 4045197572424 |
| 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 : 64.5 mm

Overall length L: 114 mm

Shank Ø D_s : 8 mm

Feed f in stainless steel > 900 N/mm²: 0.12 mm/rev.

Technical description

| | |
|---------------------------|--------|
| Number of cutting edges Z | 2 |
| Flute length L_c | 76 mm |
| Nominal Ø D_c | 7.7 mm |

| | |
|---|-------------------------|
| Feed f in stainless steel > 900 N/mm ² | 0.12 mm/rev. |
| Shank tolerance | h6 |
| Tolerance nominal Ø | m6 |
| Shank Ø D _s | 8 mm |
| Overall length L | 114 mm |
| Standard | Manufacturer's standard |
| recommended maximum drilling depth L ₂ | 64.5 mm |
| Semi-Standard | yes |
| Coating | TiAlN |
| Tool material | Solid carbide |
| Drill depth up to | 8×D |
| 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 |