

Garant
Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, Ø DC m6: 8,6 mm

Order data

Order number	123010 8,6
GTIN	4045197572509
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 : 82.1 mm

Overall length L: 142 mm

Shank Ø D_s : 10 mm

Feed f in stainless steel > 900 N/mm²: 0.15 mm/rev.

Technical description

Feed f in stainless steel > 900 N/mm ²	0.15 mm/rev.
Nominal Ø D_c	8.6 mm
Number of cutting edges Z	2
Shank tolerance	h6

Flute length L_c	95 mm
Tolerance nominal \varnothing	m6
Shank $\varnothing D_s$	10 mm
Overall length L	142 mm
Standard	Manufacturer's standard
recommended maximum drilling depth L_2	82.1 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