

Garant
Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 18 mm

Order data

Order number	123115 18
GTIN	4045197402226
Item class	11E

Description
Version:

Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry**.

Particularly high alignment accuracy due to **4 guide chamfers** which stabilise the drill even at extreme depths!

Straight major cutting edges with honed edges and special flute profile for **short chips**, even on long chipping materials.

Advantage:

High process reliability and surface quality of the hole.

Recommendation:
Maximum drilling depth:

Flute 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: h7

Number of cutting edges Z: 2

Tolerance nominal Ø: h7

recommended maximum drilling depth L_2 : 183 mm

Overall length L: 262 mm

Shank Ø D_s : 18 mm

Feed f in stainless steel < 900 N/mm²: 0.25 mm/rev.

Technical description

Feed f in stainless steel < 900 N/mm ²	0.25 mm/rev.
Shank tolerance	h6

Number of cutting edges Z	2
Nominal $\varnothing D_c$	18 mm
Flute length L_c	210 mm
Tolerance nominal \varnothing	h7
Shank $\varnothing D_s$	18 mm
Overall length L	262 mm
Standard	Manufacturer's standard
recommended maximum drilling depth L_2	183 mm
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	10xD
Point angle	135 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