

**Garant**
**Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 19 mm**

**Order data**

Order number	123115 19
GTIN	4045197402233
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  $L_c = L_2 + 1.5 \times D_c$

Machining strategy: HPC

Standard: Manufacturer's standard

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

Semi-Standard: yes

Tolerance nominal Ø: h7

recommended maximum drilling depth  $L_2$ : 205.5 mm

Overall length L: 286 mm

Shank Ø  $D_s$ : 20 mm

Feed f in stainless steel < 900 N/mm<sup>2</sup>: 0.25 mm/rev.

**Technical description**

Nominal Ø $D_c$	19 mm
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Shank tolerance	h6
Number of cutting edges Z	2
Flute length $L_c$	234 mm
Feed f in stainless steel < 900 N/mm <sup>2</sup>	0.25 mm/rev.
Tolerance nominal $\varnothing$	h7
Shank $\varnothing D_s$	20 mm
Overall length L	286 mm
Standard	Manufacturer's standard
recommended maximum drilling depth $L_2$	205.5 mm
Semi-Standard	yes
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	10xD
Point angle	135 degrees
Shank	DIN 6535 HB to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Colour ring	blue
Type of product	Jobber drill