

**Garant**
**Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 3,5 mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 123115 3,5    |
| GTIN         | 4045197401618 |
| 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  $L_2$ : 34.8 mm

Overall length L: 80 mm

Shank Ø  $D_s$ : 6 mm

Feed f in stainless steel < 900 N/mm<sup>2</sup>: 0.08 mm/rev.

**Technical description**

|                           |   |
|---------------------------|---|
| Number of cutting edges Z | 2 |
|---------------------------|---|

|   |                         |
|---|-------------------------|
| Nominal $\varnothing D_c$                         | 3.5 mm                  |
| Feed f in stainless steel < 900 N/mm <sup>2</sup> | 0.08 mm/rev.            |
| Flute length $L_c$                                | 40 mm                   |
| Shank tolerance                                   | h6                      |
| Tolerance nominal $\varnothing$                   | h7                      |
| Shank $\varnothing D_s$                           | 6 mm                    |
| Overall length L                                  | 80 mm                   |
| Standard  | Manufacturer's standard |
| recommended maximum drilling depth $L_2$          | 34.8 mm                 |
| Semi-Standard                                     | yes                     |
| Coating   | TiAlN                   |
| Tool material                                     | Solid carbide           |
| Drill depth up to                                 | 10×D                    |
| 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            |