Garant

Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, ⌀ DC h7: 3,8 mm

Order data

Order number	123115 3,8
GTIN	4045197401625
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 ⌀.
Note:
Flute length $L_C = L_2 + 1.5 \times D_C$.
Machining strategy: HPC
Standard: Manufacturer's standard
Tolerance nominal ⌀: h7
Number of cutting edges Z: 2
Semi-Standard: yes
Tolerance nominal ⌀: h7
recommended maximum drilling depth L_2: 42.3 mm
Overall length L: 86 mm
Shank ⌀ D_s: 6 mm
Feed f in stainless steel < 900 N/mm^2: 0.08 mm/rev.

Technical description

Nominal ⌀ D_C	3.8 mm

Feed f in stainless steel < 900 N/mm^2	0.08 mm/rev.
Flute length L_c	48 mm
Number of cutting edges Z	2
Shank tolerance	h6
Tolerance nominal ∅	h7
Shank ∅ D_s	6 mm
Overall length L	86 mm
Standard	Manufacturer's standard
recommended maximum drilling depth L_2	42.3 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