

## Garant

### Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, Ø DC m6: 4,5 mm or inch



#### Order data

Order number	123214 4,5
GTIN	4045197573018
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  $L_c = L_2 + 1.5 \times D_c$ .

For process reliability when using the 12×D drill, an initial centre drilling with No. 121068 – 121130 is necessary.

Machining strategy: HPC

Standard: Manufacturer's standard

Tolerance nominal Ø: m6

Number of cutting edges Z: 2

Semi-Standard: yes

Tolerance nominal Ø: m6

recommended maximum drilling depth  $L_2$ : 57.3 mm

Overall length L: 102 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
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Feed f in stainless steel > 900 N/mm <sup>2</sup>	0.08 mm/rev.
Shank tolerance	h6
Nominal Ø D <sub>c</sub>	4.5 mm
Flute length L <sub>c</sub>	64 mm
Tolerance nominal Ø	m6
Shank Ø D <sub>s</sub>	6 mm
Overall length L	102 mm
Standard	Manufacturer's standard
recommended maximum drilling depth L <sub>2</sub>	57.3 mm
Semi-Standard	yes
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	12×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