

Garant

Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, Ø DC m6 (mm or inch): 6,8 mm or inch



Order data

Order number	123214 6,8
GTIN	4045197573100
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.

Standard: Manufacturer's standard

Tolerance nominal Ø: m6

Number of cutting edges Z: 2

Tolerance nominal Ø: m6

recommended maximum drilling depth L_2 : 97.8 mm

Overall length L: 146 mm

Shank Ø D_s : 8 mm

Feed f in stainless steel > 900 N/mm²: 0.12 mm/rev.

Technical description

Feed f in stainless steel > 900 N/mm ²	0.12 mm/rev.
Flute length L_c	108 mm

Number of cutting edges Z	2
Nominal $\varnothing D_c$	6.8 mm
Shank tolerance	h6
Tolerance nominal \varnothing	m6
Shank $\varnothing D_s$	8 mm
Overall length L	146 mm
Standard	Manufacturer's standard
recommended maximum drilling depth L_2	97.8 mm
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	12xD
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