Garant

Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, ∅ DC m6 (mm or inch): 7 mm or inch

Order data

Order number	123214 7
GTIN	4045197573117
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 ∅ 3.8 mm. Up to 3.7 mm ∅ 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 ∅.
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 ∅: m6
Number of cutting edges Z: 2
Tolerance nominal ∅: m6
recommended maximum drilling depth L_2: 97.5 mm
Overall length L: 146 mm
Shank ∅ 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/mm²	0.12 mm/rev.
Flute length L_c	108 mm

Nominal ⌀ D_C	7 mm
Number of cutting edges Z	2
Shank tolerance	h6
Tolerance nominal ⌀	m6
Shank ⌀ D_s	8 mm
Overall length L	146 mm
Standard	Manufacturer's standard
recommended maximum drilling depth L_2	97.5 mm
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	12×D
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