

Garant

GARANT Master Steel FEED solid carbide stepped drill, configurable from a quantity of 20 pieces, TiAlN, Nominal Ø range from - to: 13,51-15,5mm



Order data

| | |
|--------------|-------------------|
| Order number | 125044 13,51-15,5 |
| GTIN | 4062406160159 |
| Item class | 11E |

Description

Version:

Stepped drill, finish ground to your specifications.

For producing a drilled hole and 90° countersink in a single operation.

3-flute drill, specially developed for **use at very high feed rates**. Outstandingly suitable for machines with high installed power and stable machining conditions.

Diameter tolerance first level: h7.

Drill tolerance ($\varnothing D_1$): m7.

First level tolerance ($\varnothing D_2$) h7.

Note:

Nominal \varnothing and step length are configurable (freely selectable within the range stated in the table) and ground to specification.

Technical description

| | |
|--|------------------|
| Feed f in steel < 1100 N/mm ² | 0.56 mm/rev. |
| Flute length L _c | 65 mm |
| $\varnothing D_2$ 2nd step with chamfer h7 | 16 mm |
| No. of teeth Z | 3 |
| Through-coolant | yes, with 25 bar |
| Overall length L | 115 mm |
| Shank $\varnothing D_s$ | 16 mm |
| Step height L ₁ min - max | 15.5 - 33.75 mm |

| | |
|---------------------------------|-------------------------|
| Nominal $\varnothing D_c$ | 13.51 - 15.5 mm |
| Series | Master Steel |
| Coating | TiAlN |
| Tool material | Solid carbide |
| Standard | Manufacturer's standard |
| Tolerance nominal \varnothing | m7 |
| Point angle | 145 degrees |
| Shank | DIN 6535 HA to h6 |
| Countersink angle | 90 degrees |
| Machining strategy | HPC |
| Colour ring | green |
| Type of product | Stepped drill |

User data

| | Suitability | V_c | ISO code |
|--------------------------------|---|-----------|----------|
| Steel < 500 N/mm ² | suitable | 160 m/min | P |
| Steel < 750 N/mm ² | suitable | 140 m/min | P |
| Steel < 900 N/mm ² | suitable | 130 m/min | P |
| Steel < 1100 N/mm ² | suitable | 110 m/min | P |
| Steel < 1400 N/mm ² | suitable | 90 m/min | P |
| Steel < 55 HRC | suitable | 60 m/min | H |
| INOX < 900 N/mm ² | suitable | 60 m/min | M |
| INOX > 900 N/mm ² | suitable | 50 m/min | M |
| Ti > 850 N/mm ² | suitable only under restricted conditions | 40 m/min | S |
| GG | suitable | 130 m/min | K |
| GGG | suitable | 80 m/min | K |
| Uni | suitable | | |
| wet maximum | suitable | | |

wet minimum

suitable