

## Garant

**GARANT Master Steel FEED solid carbide stepped drill, configurable from a quantity of 3 pieces, TiAlN, Nominal  $\varnothing$  range from - to: 15,51-17,5mm**



### Order data

|              |                   |
|--------------|-------------------|
| Order number | 125040 15,51-17,5 |
| GTIN         | 4062406159764     |
| 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

|  |                  |
|--|------------------|
| Overall length L                           | 123 mm           |
| Shank $\varnothing D_s$                    | 18 mm            |
| Feed f in steel < 1100 N/mm <sup>2</sup>   | 0.61 mm/rev.     |
| $\varnothing D_2$ 2nd step with chamfer h7 | 18 mm            |
| No. of teeth Z                             | 3                |
| Through-coolant                            | yes, with 25 bar |
| Flute length L <sub>c</sub>                | 73 mm            |
| Step height L <sub>1</sub> min - max       | 17.5 - 40.15 mm  |

|                                 |                         |
|---------------------------------|-------------------------|
| Nominal $\varnothing D_c$       | 15.51 - 17.5 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 <sup>2</sup>  | suitable                                  | 160 m/min | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable                                  | 140 m/min | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable                                  | 130 m/min | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable                                  | 110 m/min | P        |
| Steel < 1400 N/mm <sup>2</sup> | suitable                                  | 90 m/min  | P        |
| Steel < 55 HRC                 | suitable                                  | 60 m/min  | H        |
| INOX < 900 N/mm <sup>2</sup>   | suitable                                  | 60 m/min  | M        |
| INOX > 900 N/mm <sup>2</sup>   | suitable                                  | 50 m/min  | M        |
| Ti > 850 N/mm <sup>2</sup>     | 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