

Garant

GARANT Master Steel FEED solid carbide stepped drill, configurable from a quantity of 15 pieces, TiAlN, Nominal Ø range from - to: 8,51-9,5mm



Order data

Order number	125043 8,51-9,5
GTIN	4062406160029
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	89 mm
No. of teeth Z	3
Flute length L_c	47 mm
Feed f in steel < 1100 N/mm ²	0.44 mm/rev.
Through-coolant	yes, with 25 bar
$\varnothing D_2$ 2nd step with chamfer h7	10 mm
Shank $\varnothing D_s$	10 mm
Step height L_1 min - max	9.5 - 25.85 mm

Nominal $\varnothing D_c$	8.51 - 9.5 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