

## Garant

**GARANT Master Steel FEED solid carbide stepped drill, configurable from a quantity of 20 pieces, TiAlN, Nominal Ø range from - to: 15,51-17,5mm**



### Order data

Order number	125044 15,51-17,5
GTIN	4062406160166
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

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