Garant

GARANT Master Steel FEED solid carbide stepped drill, configurable from a quantity of 3 pieces, TiAlN, Nominal ⌀ range from - to: 8,51-9,5mm

Order data

Order number	125040 8,51-9,5
GTIN	4062406159726
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 (⌀D_1): m7.
First level tolerance (⌀D_2) h7.
Note:
Nominal ⌀ 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	0.44 mm/rev.
No. of teeth Z	3
Flute length L_c	47 mm
⌀ D_2 2nd step with chamfer h7	10 mm
Through-coolant	yes, with 25 bar
Overall length L	89 mm
Shank ⌀ D_s	10 mm
Step height L_1 min - max	9.5 - 25.85 mm

Nominal ⌀ D_C	8.51 - 9.5 mm
Series	Master Steel
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Tolerance nominal ⌀	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/mm²	suitable	160 m/min	P
Steel < 750 N/mm²	suitable	140 m/min	P
Steel < 900 N/mm²	suitable	130 m/min	P
Steel < 1100 N/mm²	suitable	110 m/min	P
Steel < 1400 N/mm²	suitable	90 m/min	P
Steel < 55 HRC	suitable	60 m/min	H
INOX < 900 N/mm²	suitable	60 m/min	M
INOX > 900 N/mm²	suitable	50 m/min	M
Ti > 850 N/mm²	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