

## Garant

**GARANT Master Steel FEED solid carbide stepped drill, configurable from a quantity of 10 pieces, TiAlN, Nominal Ø range from - to: 11,51-13,5mm**



### Order data

Order number	125042 11,51-13,5
GTIN	4062406159948
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

Step height $L_1$ min - max	13.5 - 33 mm
Shank $\varnothing D_s$	14 mm
$\varnothing D_2$ 2nd step with chamfer h7	14 mm
Feed $f$ in steel < 1100 N/mm <sup>2</sup>	0.5 mm/rev.
Overall length $L$	107 mm
Flute length $L_c$	60 mm
No. of teeth $Z$	3
Through-coolant	yes, with 25 bar

Nominal $\varnothing D_c$	11.51 - 13.5 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	40 m/min	S
GG	suitable	130 m/min	K
GGG	suitable	80 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable		

