Garant

GARANT Master Steel SPEED solid carbide drill, Weldon shank DIN 6535 HB, TiAlN, ⌀ DC h7: 9,2 mm

Order data

Order number	122416 9,2
GTIN	4045197790637
Item class	11E

Description

Version:
Developed for use with **very high cutting speeds**. Outstandingly suitable for machines with **low installed power** and high speeds.
· **Clear reduction in cutting forces due to special cutter geometry.**
· **Coating for best wear resistance even at high process temperatures.**
· **Polished flutes for good chip clearance.**
A **slim chisel point** and the **special arrangement of the 4 guide chamfers** ensure **high positioning and alignment accuracy**. Optimised micro-geometry for increased working life and performance capability.
Recommendation:
Maximum drilling depth:
clamping slot length (see table) less 1.5×nominal ⌀.
Note:
Flute length $L_C = L_2 + 1.5 \times D_C$.
Standard: DIN 6537 K
Tolerance nominal ⌀: h7
Number of cutting edges Z: 2
Tolerance nominal ⌀: h7
recommended maximum drilling depth L_2: 33.2 mm
Overall length L: 89 mm
Shank ⌀ D_s: 10 mm
Feed f in steel < 1100 N/mm^2: 0.26 mm/rev.

Technical description

Tolerance nominal ⌀	h7

Nominal Ø D_C	9.2 mm
Flute length L_c	47 mm
Number of cutting edges Z	2
Standard	DIN 6537 K
Overall length L	89 mm
Shank tolerance	h6
Feed f in steel < 1100 N/mm²	0.26 mm/rev.
Shank Ø D_s	10 mm
recommended maximum drilling depth L_2	33.2 mm
Series	GARANT Master Steel
Coating	TiAlN
Tool material	solid carbide
	4×D
Point angle	135 °
Shank	DIN 6535 HB to h6
Through-coolant	no
Machining strategy	HPC
Semi-Standard	yes
Colour ring	green
Type of product	Jobber drill

User data

	Suitability	V_c	ISO code
Steel < 500 N/mm²	suitable	170 m/min	P
Steel < 750 N/mm²	suitable	150 m/min	P
Steel < 900 N/mm²	suitable	120 m/min	P
Steel < 1100 N/mm²	suitable	110 m/min	P
Steel < 1400 N/mm²	suitable only under restricted conditions	60 m/min	P

GG	suitable	110 m/min	K
GGG	suitable	100 m/min	K
Uni	suitable		
wet maximum	suitable		