

Garant

GARANT Master Steel SPEED solid carbide drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 19,8mm


Order data

| | |
|--------------|---------------|
| Order number | 122416 19,8 |
| GTIN | 4045197791221 |
| 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.

Note:

Flute length $L_c = L_2 + 1.5 \times D_c$.

Technical description

| | |
|---------------------------|------------|
| Standard | DIN 6537 K |
| Nominal Ø D_c | 19.8 mm |
| Overall length L | 131 mm |
| Shank Ø D_s | 20 mm |
| Tolerance nominal Ø | h7 |
| Number of cutting edges Z | 2 |
| Shank tolerance | h6 |
| Flute length L_c | 79 mm |

| | |
|---|-------------------|
| Feed f in steel < 1100 N/mm ² | 0.38 mm/rev. |
| recommended maximum drilling depth L ₂ | 49.3 mm |
| Series | Master Steel |
| Coating | TiAlN |
| Tool material | solid carbide |
| Version | 4xD |
| Point angle | 135 degrees |
| 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/mm ² | suitable | 170 m/min | P |
| Steel < 750 N/mm ² | suitable | 150 m/min | P |
| Steel < 900 N/mm ² | suitable | 120 m/min | P |
| Steel < 1100 N/mm ² | suitable | 110 m/min | P |
| Steel < 1400 N/mm ² | 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 | | |