

**Garant**
**GARANT Master Steel SPEED solid carbide drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 8,7mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 122426 8,7    |
| GTIN         | 4045197791801 |
| 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**

|  |              |
|--|--------------|
| Feed f in steel < 1100 N/mm <sup>2</sup> | 0.26 mm/rev. |
| Standard                                 | DIN 6537 K   |
| Shank tolerance                          | h6           |
| Tolerance nominal Ø                      | h7           |
| Number of cutting edges Z                | 2            |
| Flute length L <sub>c</sub>              | 47 mm        |
| Nominal Ø D <sub>c</sub>                 | 8.7 mm       |
| Overall length L                         | 89 mm        |

|  |                   |
|--|-------------------|
| Shank $\varnothing D_s$                  | 10 mm             |
| recommended maximum drilling depth $L_2$ | 34 mm             |
| Series                                   | Master Steel      |
| Coating                                  | TiAlN             |
| Tool material                            | solid carbide     |
| Version                                  | 4xD               |
| Point angle                              | 135 degrees       |
| Shank                                    | DIN 6535 HB to h6 |
| Through-coolant                          | Yes, with 25 bar  |
| 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 <sup>2</sup>  | suitable                                  | 220 m/min | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable                                  | 200 m/min | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable                                  | 180 m/min | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable                                  | 170 m/min | P        |
| Steel < 1400 N/mm <sup>2</sup> | suitable                                  | 90 m/min  | P        |
| INOX < 900 N/mm <sup>2</sup>   | suitable only under restricted conditions | 75 m/min  | M        |
| GG                             | suitable                                  | 160 m/min | K        |
| GGG                            | suitable                                  | 130 m/min | K        |
| Uni                            | suitable                                  |           |          |
| wet maximum                    | suitable                                  |           |          |
| wet minimum                    | suitable                                  |           |          |

