

**Garant**

**GARANT Master Steel SPEED solid carbide drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 13,8 mm**


**Order data**

Order number	122426 13,8
GTIN	4045197792204
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 Ø.

**Note:**

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

Standard: DIN 6537 K

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

Tolerance nominal Ø: h7

recommended maximum drilling depth  $L_2$ : 39.3 mm

Overall length L: 107 mm

Shank Ø  $D_s$ : 14 mm

Feed f in steel < 1100 N/mm<sup>2</sup>: 0.31 mm/rev.

**Technical description**

Standard	DIN 6537 K
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Number of cutting edges Z	2
Shank tolerance	h6
Shank $\varnothing D_s$	14 mm
Overall length L	107 mm
Flute length $L_c$	60 mm
Feed f in steel < 1100 N/mm <sup>2</sup>	0.31 mm/rev.
Tolerance nominal $\varnothing$	h7
Nominal $\varnothing D_c$	13.8 mm
recommended maximum drilling depth $L_2$	39.3 mm
Series	GARANT Master Steel
Coating	TiAlN
Tool material	solid carbide
	4xD
Point angle	135 °
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		