

## Garant

**GARANT Master Steel FEED solid carbide drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7 (mm or inch): 8,2**



### Order data

Order number	122436 8,2
GTIN	4045197792877
Item class	11E

### Description

#### Version:

**3-flute drill**, specially developed for **use at very high feed rates**. Outstandingly suitable for machines with **high installed power** and stable machining conditions.

- **Special cutter geometry with stable cutting edges and large clearance at the centre enables very high feed rates.**
- **The patented tip is optimised for chip flow and generates low cutting pressure with good chip breakage.**
- **With a 145° point angle for low burrs on emerging from through holes.**

The **sector-leading technology of the chisel point** guarantees **optimum self-centring behaviour** and permits spot drilling on irregular surfaces. 3 guide chamfers guarantee a stable exit from the hole and an exact roundness of the hole.

#### 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: 3

Tolerance nominal Ø: h7

recommended maximum drilling depth  $L_2$ : 34.7 mm

Overall length L: 89 mm

Shank Ø  $D_s$ : 10 mm

Feed f in steel < 1100 N/mm<sup>2</sup>: 0.44 mm/rev.

### Technical description

Shank Ø $D_s$	10 mm
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Flute length $L_c$	47 mm
Overall length $L$	89 mm
Feed $f$ in steel $< 1100 \text{ N/mm}^2$	0.44 mm/rev.
Standard	DIN 6537 K
Tolerance nominal $\varnothing$	h7
Nominal $\varnothing D_c$	8.2 mm
Number of cutting edges $Z$	3
recommended maximum drilling depth $L_2$	34.7 mm
Series	Master Steel
Coating	TiAlN
Tool material	solid carbide
Version	4xD
Point angle	145 °
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 $< 500 \text{ N/mm}^2$	suitable	160 m/min	P
Steel $< 750 \text{ N/mm}^2$	suitable	140 m/min	P
Steel $< 900 \text{ N/mm}^2$	suitable	130 m/min	P
Steel $< 1100 \text{ N/mm}^2$	suitable	110 m/min	P
Steel $< 1400 \text{ N/mm}^2$	suitable	90 m/min	P
Steel $< 55 \text{ HRC}$	suitable	60 m/min	H
INOX $< 900 \text{ N/mm}^2$	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 only under restricted conditions	40 m/min	S
GG	suitable	130 m/min	K
GGG	suitable	80 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable		