

Garant

GARANT Master Steel FEED solid carbide drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7 (mm or inch): 8,4



Order data

Order number	122436 8,4
GTIN	4045197792891
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 : 34.4 mm

Overall length L: 89 mm

Shank Ø D_s : 10 mm

Feed f in steel < 1100 N/mm²: 0.44 mm/rev.

Technical description

Tolerance nominal Ø	h7
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Flute length L_c	47 mm
Overall length L	89 mm
Number of cutting edges Z	3
Feed f in steel < 1100 N/mm ²	0.44 mm/rev.
Nominal $\varnothing D_c$	8.4 mm
Shank $\varnothing D_s$	10 mm
Standard	DIN 6537 K
recommended maximum drilling depth L_2	34.4 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 N/mm ²	suitable	160 m/min	P
Steel < 750 N/mm ²	suitable	140 m/min	P
Steel < 900 N/mm ²	suitable	130 m/min	P
Steel < 1100 N/mm ²	suitable	110 m/min	P
Steel < 1400 N/mm ²	suitable	90 m/min	P
Steel < 55 HRC	suitable	60 m/min	H
INOX < 900 N/mm ²	suitable	60 m/min	M

INOX > 900 N/mm ²	suitable	50 m/min	M
Ti > 850 N/mm ²	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		