Garant

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

Order data

Order number	122726 7,8
GTIN	4045197795175
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 operating 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 145° tip angle for low burr formation when drilling 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 $L_C = L_2 + 1.5 \times D_C$.

Technical description

Flute length L_c	53 mm
Standard	DIN 6537
Number of cutting edges Z	3
Overall length L	91 mm
Feed f in steel < 1100 N/mm^2	0.37 mm/rev.
Shank Ø D_s	8 mm
Nominal Ø D_C	7.8 mm

Tolerance nominal ∅	h7
recommended maximum drilling depth L_2	41.3 mm
Series	Master Steel
Coating	TiAlN
Tool material	solid carbide
Version	6×D
Point angle	145 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/mm²	suitable	160 m/min	P
Steel < 750 N/mm²	suitable	140 m/min	P
Steel < 900 N/mm²	suitable	130 m/min	P
Steel < 1100 N/mm²	suitable	110 m/min	P
Steel < 1400 N/mm²	suitable	90 m/min	P
Steel < 55 HRC	suitable	60 m/min	H
INOX < 900 N/mm²	suitable	60 m/min	M
INOX > 900 N/mm²	suitable	50 m/min	M
GG	suitable	130 m/min	K
GGG	suitable	80 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable		