

## Garant

### GARANT Master Steel FEED solid carbide drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 8,5mm



#### Order data

Order number	122726 8,5
GTIN	4045197795243
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

Nominal Ø $D_c$	8.5 mm
Flute length $L_c$	61 mm
Feed $f$ in steel < 1100 N/mm <sup>2</sup>	0.44 mm/rev.
Standard	DIN 6537
Overall length $L$	103 mm
Shank Ø $D_s$	10 mm
Tolerance nominal Ø	h7

Number of cutting edges Z	3
recommended maximum drilling depth L <sub>2</sub>	48.3 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 <sub>c</sub>	ISO code
Steel < 500 N/mm <sup>2</sup>	suitable	160 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	140 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	130 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	110 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	90 m/min	P
Steel < 55 HRC	suitable	60 m/min	H
INOX < 900 N/mm <sup>2</sup>	suitable	60 m/min	M
INOX > 900 N/mm <sup>2</sup>	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		

