

## Garant

**GARANT Master Steel FEED solid carbide drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 10,5mm**



### Order data

|              |               |
|--------------|---------------|
| Order number | 122726 10,5   |
| GTIN         | 4045197795441 |
| 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

|   |             |
|---|-------------|
| Feed $f$ in steel $< 1100 \text{ N/mm}^2$ | 0.5 mm/rev. |
| Standard                                  | DIN 6537    |
| Overall length $L$                        | 118 mm      |
| Shank $\varnothing D_s$                   | 12 mm       |
| Tolerance nominal $\varnothing$           | h7          |
| Flute length $L_c$                        | 71 mm       |
| Nominal $\varnothing D_c$                 | 10.5 mm     |

|   |                   |
|---|-------------------|
| Number of cutting edges Z                         | 3                 |
| recommended maximum drilling depth L <sub>2</sub> | 55.3 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    |                |          |

