

Garant

GARANT Master Steel FEED solid carbide drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 19,5mm


Order data

| | |
|--------------|---------------|
| Order number | 122726 19,5 |
| GTIN | 4045197795892 |
| 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

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|--|--------------|
| Nominal Ø D_c | 19.5 mm |
| Flute length L_c | 101 mm |
| Number of cutting edges Z | 3 |
| Tolerance nominal Ø | h7 |
| Shank Ø D_s | 20 mm |
| Feed f in steel < 1100 N/mm ² | 0.69 mm/rev. |
| Overall length L | 153 mm |

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|---|-------------------|
| Standard | DIN 6537 |
| recommended maximum drilling depth L ₂ | 71.8 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/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 |
| GG | suitable | 130 m/min | K |
| GGG | suitable | 80 m/min | K |
| Uni | suitable | | |
| wet maximum | suitable | | |
| wet minimum | suitable | | |

