Garant

GARANT Master Steel SPEED solid carbide drill, Weldon shank DIN 6535 HB, TiAlN, ∅ DC h7: 9,35 mm

Order data

Order number	122426 9,35
GTIN	4062406254261
Item class	11E

Description

Version:
Developed for use with **very high cutting speeds**. Outstandingly suitable for machines with **low installed power** and high speeds.
· **Clear reduction in cutting forces due to special cutter geometry.**
· **Coating for best wear resistance even at high process temperatures.**
· **Polished flutes for good chip clearance.**
A **slim chisel point** and the **special arrangement of the 4 guide chamfers** ensure **high positioning and alignment accuracy**. Optimised micro-geometry for increased working life and performance capability.
Recommendation:
Maximum drilling depth:
clamping slot length (see table) less 1.5×nominal ∅.
Note:
Flute length $L_C = L_2 + 1.5 \times D_C$.
Standard: DIN 6537 K
Tolerance nominal ∅: h7
Number of cutting edges Z: 2
Tolerance nominal ∅: h7
recommended maximum drilling depth L_2: 32.9 mm
Overall length L: 89 mm
Shank ∅ D_s: 10 mm
Feed f in steel < 1100 N/mm²: 0.26 mm/rev.

Technical description

recommended maximum drilling depth L_2	32.9 mm

Overall length L	89 mm
Flute length L_c	47 mm
Standard	DIN 6537 K
Feed f in steel < 1100 N/mm²	0.26 mm/rev.
Shank ⌀ D_s	10 mm
Tolerance nominal ⌀	h7
Number of cutting edges Z	2
Nominal ⌀ D_C	9.35 mm
Shank tolerance	h6
Series	GARANT Master Steel
Coating	TiAlN
Tool material	solid carbide
	4×D
Point angle	135 °
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	220 m/min	P
Steel < 750 N/mm²	suitable	200 m/min	P
Steel < 900 N/mm²	suitable	180 m/min	P
Steel < 1100 N/mm²	suitable	170 m/min	P
Steel < 1400 N/mm²	suitable	90 m/min	P

INOX < 900 N/mm²	suitable only under restricted conditions	75 m/min	M
GG	suitable	160 m/min	K
GGG	suitable	130 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable		