

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



### Order data

Order number	122476 8,5
GTIN	4067263123316
Item class	11E

### Description

#### Version:

**Robust drill design and optimised special point geometry** for the **best possible chip formation and reliable chip breakage** with **higher feed rates at the same time**. **Advanced micro-geometry, convex cutting edge and conical profile grinding** to provide additional stability for the main cutting edge. **Optimised flute geometry and patented face geometry** for **reliable chip evacuation** in steel materials and cast material. **High-performance coating** of the latest generation.

#### Note:

Flute length  $L_c = L_2 + 1.5 \times D_c$ .

### Technical description

Nominal Ø $D_c$	8.5 mm
Tolerance nominal Ø	h7
Standard	DIN 6537 K
Flute length $L_c$	47 mm
Overall length L	89 mm
recommended maximum drilling depth $L_2$	34.3 mm
Number of cutting edges Z	2
Shank Ø $D_s$	10 mm
Feed f in steel < 1100 N/mm <sup>2</sup>	0.27 mm/rev.
Series	Master Steel

Coating	TiAlN
Tool material	Solid carbide
Version	4xD
Point angle	140 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	170 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	155 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	145 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	130 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	110 m/min	P
Steel < 55 HRC	suitable	60 m/min	H
INOX < 900 N/mm <sup>2</sup>	suitable only under restricted conditions	55 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable only under restricted conditions	45 m/min	M
GG	suitable	130 m/min	K
GGG	suitable	90 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable		
Air	suitable		

