

GARANT Master Steel solid carbide high-performance drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 13,8mm



Order data

| | |
|--------------|---------------|
| Order number | 122762 13,8 |
| GTIN | 4067263124368 |
| 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

| | |
|--|--------------|
| Flute length L_c | 77 mm |
| Number of cutting edges Z | 2 |
| Tolerance nominal Ø | h7 |
| Nominal Ø D_c | 13.8 mm |
| recommended maximum drilling depth L_2 | 56.3 mm |
| Feed f in steel < 1100 N/mm ² | 0.37 mm/rev. |
| Overall length L | 124 mm |
| Standard | DIN 6537 |
| Shank Ø D_s | 14 mm |
| Series | Master Steel |

| | |
|--------------------|-------------------|
| Coating | TiAlN |
| Tool material | Solid carbide |
| Version | 6xD |
| Point angle | 140 degrees |
| Shank | DIN 6535 HB to h6 |
| Through-coolant | Yes, with 25 bar |
| Machining strategy | HPC |
| Semi-Standard | yes |
| Type of product | Jobber drill |

User data

| | Suitability | V _c | ISO code |
|--------------------------------|---|----------------|----------|
| Steel < 500 N/mm ² | suitable | 170 m/min | P |
| Steel < 750 N/mm ² | suitable | 155 m/min | P |
| Steel < 900 N/mm ² | suitable | 145 m/min | P |
| Steel < 1100 N/mm ² | suitable | 130 m/min | P |
| Steel < 1400 N/mm ² | suitable | 110 m/min | P |
| Steel < 55 HRC | suitable | 60 m/min | H |
| INOX < 900 N/mm ² | suitable only under restricted conditions | 55 m/min | M |
| INOX > 900 N/mm ² | 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 | | |

