

**Garant**

**GARANT Master Steel solid carbide high-performance drill, plain shank DIN 6535 HB, TiAlN, Ø DC h7: 7,8mm**



## Order data

|              |               |
|--------------|---------------|
| Order number | 122762 7,8    |
| GTIN         | 4067263124061 |
| 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 $L_c$                        | 53 mm        |
| Feed $f$ in steel $< 1100 \text{ N/mm}^2$ | 0.25 mm/rev. |
| Overall length $L$                        | 91 mm        |
| recommended maximum drilling depth $L_2$  | 41.3 mm      |
| Nominal $\varnothing D_c$                 | 7.8 mm       |
| Number of cutting edges $Z$               | 2            |
| Tolerance nominal $\varnothing$           | h7           |
| Standard                                  | DIN 6537     |
| Shank $\varnothing D_s$                   | 8 mm         |

|                    |                   |
|--------------------|-------------------|
| Series             | Master Steel      |
| Coating            | TiAlN             |
| Tool material      | Solid carbide     |
| Version            | 6×D               |
| 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 <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                                  |                |          |

