Garant

GARANT Master Steel solid carbide HPC drill, plain shank DIN 6535 HB, TiAlN, ⌀ DC h7: 3,4mm

Order data

Order number	122471 3,4
GTIN	4067263122104
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

recommended maximum drilling depth L_2	14.9 mm
Feed f in steel < 1100 N/mm^2	0.13 mm/rev.
Standard	DIN 6537 K
Nominal ⌀ D_C	3.4 mm
Number of cutting edges Z	2
Overall length L	62 mm
Tolerance nominal ⌀	h7
Shank ⌀ D_s	6 mm
Flute length L_c	20 mm

Series	Master Steel
Coating	TiAlN
Tool material	Solid carbide
Version	4×D
Point angle	140 degrees
Shank	DIN 6535 HB to h6
Through-coolant	no
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	115 m/min	P
Steel < 750 N/mm²	suitable	105 m/min	P
Steel < 900 N/mm²	suitable	100 m/min	P
Steel < 1100 N/mm²	suitable	70 m/min	P
Steel < 1400 N/mm²	suitable	60 m/min	P
GG	suitable	110 m/min	K
GGG	suitable	75 m/min	K
Uni	suitable		
wet maximum	suitable		
dry	suitable		