

**Garant**

**GARANT Master Steel solid carbide HPC drill, plain shank DIN 6535 HB, TiAlN, Ø DC h7: 13mm**



## Order data

Order number	122471 13
GTIN	4067263122784
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 $L_c$	60 mm
Standard	DIN 6537 K
Overall length $L$	107 mm
Tolerance nominal Ø	h7
Number of cutting edges $Z$	2
Nominal Ø $D_c$	13 mm
Shank Ø $D_s$	14 mm
Feed $f$ in steel < 1100 N/mm <sup>2</sup>	0.36 mm/rev.
recommended maximum drilling depth $L_2$	40.5 mm

Series	Master Steel
Coating	TiAlN
Tool material	Solid carbide
Version	4xD
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 <sub>c</sub>	ISO code
Steel < 500 N/mm <sup>2</sup>	suitable	115 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	105 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	100 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	70 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	60 m/min	P
GG	suitable	110 m/min	K
GGG	suitable	75 m/min	K
Uni	suitable		
wet maximum	suitable		
dry	suitable		