

**Garant**

**GARANT Master Steel solid carbide HPC drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 9,8mm**

**Order data**

Order number	122471 9,8
GTIN	4067263122654
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 $L_c$	47 mm
Feed $f$ in steel $< 1100 \text{ N/mm}^2$	0.3 mm/rev.
Nominal Ø $D_c$	9.8 mm
Overall length $L$	89 mm
Number of cutting edges $Z$	2
recommended maximum drilling depth $L_2$	32.3 mm
Standard	DIN 6537 K
Tolerance nominal Ø	h7
Shank Ø $D_s$	10 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		