

Garant

GARANT Master Steel solid carbide HPC drill, plain shank DIN 6535 HB, TiAlN, Ø DC h7: 6,9mm

**Order data**

Order number	122471 6,9
GTIN	4067263122432
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

Shank Ø D_s	8 mm
Feed f in steel $< 1100 \text{ N/mm}^2$	0.23 mm/rev.
recommended maximum drilling depth L_2	23.7 mm
Number of cutting edges Z	2
Tolerance nominal Ø	h7
Flute length L_c	34 mm
Standard	DIN 6537 K
Overall length L	79 mm
Nominal Ø D_c	6.9 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 _c	ISO code
Steel < 500 N/mm ²	suitable	115 m/min	P
Steel < 750 N/mm ²	suitable	105 m/min	P
Steel < 900 N/mm ²	suitable	100 m/min	P
Steel < 1100 N/mm ²	suitable	70 m/min	P
Steel < 1400 N/mm ²	suitable	60 m/min	P
GG	suitable	110 m/min	K
GGG	suitable	75 m/min	K
Uni	suitable		
wet maximum	suitable		
dry	suitable		