

Garant

GARANT Master Steel solid carbide HPC drill, plain shank DIN 6535 HB, TiAlN, Ø DC h7: 4,5mm



Order data

| | |
|--------------|---------------|
| Order number | 122471 4,5 |
| GTIN | 4067263122210 |
| 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

| | |
|--|--------------|
| Tolerance nominal Ø | h7 |
| Standard | DIN 6537 K |
| Nominal Ø D_c | 4.5 mm |
| Flute length L_c | 24 mm |
| Feed f in steel < 1100 N/mm ² | 0.16 mm/rev. |
| Shank Ø D_s | 6 mm |
| Number of cutting edges Z | 2 |
| Overall length L | 66 mm |
| recommended maximum drilling depth L_2 | 17.3 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 | | |