

## GARANT Master Steel solid carbide HPC drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 5,2mm



### Order data

|              |               |
|--------------|---------------|
| Order number | 122471 5,2    |
| GTIN         | 4067263122272 |
| 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

|                                           |              |
|-------------------------------------------|--------------|
| Nominal Ø $D_c$                           | 5.2 mm       |
| Feed $f$ in steel $< 1100 \text{ N/mm}^2$ | 0.18 mm/rev. |
| Shank Ø $D_s$                             | 6 mm         |
| Flute length $L_c$                        | 28 mm        |
| Number of cutting edges $Z$               | 2            |
| recommended maximum drilling depth $L_2$  | 20.2 mm      |
| Overall length $L$                        | 66 mm        |
| Tolerance nominal Ø                       | h7           |
| Standard                                  | DIN 6537 K   |
| 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    |                |          |