

Garant**GARANT Master Steel solid carbide high-performance drill, plain shank DIN 6535 HB, TiAlN, Ø DC h7: 9,35mm****Order data**

Order number	122762 9,35
GTIN	4069515042222
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

recommended maximum drilling depth L_2	47.1 mm
Overall length L	103 mm
Standard	DIN 6537 L
Tolerance nominal Ø	h7
Feed f in steel $< 1100 \text{ N/mm}^2$	0.29 mm/rev.
Number of cutting edges Z	2
Shank Ø D_s	10 mm
Nominal Ø D_c	9.35 mm
Flute length L_c	61.1 mm

Data sheet

Series	Master Steel
Coating	TiAlN
Tool material	Solid carbide
Version	6×D
Point angle	140 degrees
Shank	DIN 6535 HB to h6
Through-coolant	Yes, with 25 bar
Machining strategy	HPC
Semi-Standard	yes
Type of product	Jobber drill

User data

	Suitability	V _c	ISO code
Steel < 500 N/mm ²	suitable	170 m/min	P
Steel < 750 N/mm ²	suitable	155 m/min	P
Steel < 900 N/mm ²	suitable	145 m/min	P
Steel < 1100 N/mm ²	suitable	130 m/min	P
Steel < 1400 N/mm ²	suitable	110 m/min	P
Steel < 55 HRC	suitable	60 m/min	H
INOX < 900 N/mm ²	suitable only under restricted conditions	55 m/min	M
INOX > 900 N/mm ²	suitable only under restricted conditions	45 m/min	M
GG	suitable	130 m/min	K
GGG	suitable	90 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable		
Air	suitable		

