

## Garant

### GARANT Master Steel FEED solid carbide drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 7,6mm



#### Order data

|              |               |
|--------------|---------------|
| Order number | 123036 7,6    |
| GTIN         | 4045197841698 |
| Item class   | 11E           |

#### Description

##### Version:

**3-flute drill**, specially developed for **use at very high feed rates**. Outstandingly suitable for machines with **high installed power** and stable machining conditions.

- **Special cutter geometry with stable cutting edges and large clearance at the centre enables very high feed rates.**
- **The patented tip is optimised for chip flow and generates low cutting pressure with good chip breakage.**

The **sector-leading technology of the drill point** guarantees **optimum self-centring behaviour**. 3 guide chamfers guarantee a stable exit from the hole and an exact roundness of the hole.

##### Note:

Flute length  $L_c = L_2 + 1.5 \times D_c$ .

#### Technical description

| Standard  | Manufacturer's standard |
|---|-------------------------|
| Number of cutting edges Z                         | 3                       |
| Nominal Ø D <sub>c</sub>                          | 7.6 mm                  |
| Flute length L <sub>c</sub>                       | 76 mm                   |
| Feed f in steel < 1100 N/mm <sup>2</sup>          | 0.37 mm/rev.            |
| recommended maximum drilling depth L <sub>2</sub> | 64.6 mm                 |
| Overall length L                                  | 114 mm                  |

|                                 |                   |
|---------------------------------|-------------------|
| Shank $\varnothing D_s$         | 8 mm              |
| Tolerance nominal $\varnothing$ | h7                |
| Series                          | Master Steel      |
| Coating                         | TiAlN             |
| Tool material                   | Solid carbide     |
| Version                         | 8xD               |
| Point angle                     | 140 degrees       |
| Shank                           | DIN 6535 HB to h6 |
| Through-coolant                 | yes, to 25 bar    |
| 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 <sup>2</sup>  | suitable                                  | 120 m/min | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable                                  | 110 m/min | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable                                  | 100 m/min | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable                                  | 90 m/min  | P        |
| Steel < 1400 N/mm <sup>2</sup> | suitable                                  | 70 m/min  | P        |
| Steel < 55 HRC                 | suitable                                  | 60 m/min  | H        |
| INOX < 900 N/mm <sup>2</sup>   | suitable                                  | 55 m/min  | M        |
| INOX > 900 N/mm <sup>2</sup>   | suitable                                  | 50 m/min  | M        |
| Ti > 850 N/mm <sup>2</sup>     | suitable only under restricted conditions | 40 m/min  | S        |
| GG                             | suitable                                  | 120 m/min | K        |
| GGG                            | suitable                                  | 80 m/min  | K        |
| Uni                            | suitable                                  |           |          |

|             |          |
|-------------|----------|
| wet maximum | suitable |
| wet minimum | suitable |