

## Garant

### GARANT Master Steel FEED solid carbide drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 10mm



#### Order data

|              |               |
|--------------|---------------|
| Order number | 123036 10     |
| GTIN         | 4045197841933 |
| 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

|   |              |
|---|--------------|
| Shank Ø D <sub>s</sub>                            | 10 mm        |
| Number of cutting edges Z                         | 3            |
| Flute length L <sub>c</sub>                       | 95 mm        |
| Tolerance nominal Ø                               | h7           |
| Nominal Ø D <sub>c</sub>                          | 10 mm        |
| recommended maximum drilling depth L <sub>2</sub> | 80 mm        |
| Feed f in steel < 1100 N/mm <sup>2</sup>          | 0.44 mm/rev. |

|                    |                         |
|--------------------|-------------------------|
| Overall length L   | 142 mm                  |
| Standard           | Manufacturer's standard |
| 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 <sub>c</sub> | 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 |