

Garant

GARANT Master Steel FEED solid carbide drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 6,5mm



Order data

| | |
|--------------|---------------|
| Order number | 123236 6,5 |
| GTIN | 4045197842701 |
| 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 $L_c = L_2 + 1.5 \times D_c$.

For process reliability when using the 12xD deep-hole drill, an initial centre drilling with an NC spotting drill No. 121130 with **155° point angle** is necessary.

Technical description

| Standard | Manufacturer's standard |
|--|-------------------------|
| Nominal Ø D_c | 6.5 mm |
| Flute length L_c | 108 mm |
| Number of cutting edges Z | 3 |
| recommended maximum drilling depth L_2 | 98.3 mm |
| Tolerance nominal Ø | h7 |

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|--|-------------------|
| Overall length L | 146 mm |
| Shank $\varnothing D_s$ | 8 mm |
| Feed f in steel < 1100 N/mm ² | 0.37 mm/rev. |
| Series | Master Steel |
| Coating | TiAlN |
| Tool material | Solid carbide |
| Version | 12xD |
| 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 ² | suitable | 120 m/min | P |
| Steel < 750 N/mm ² | suitable | 110 m/min | P |
| Steel < 900 N/mm ² | suitable | 100 m/min | P |
| Steel < 1100 N/mm ² | suitable | 90 m/min | P |
| Steel < 1400 N/mm ² | suitable | 70 m/min | P |
| Steel < 55 HRC | suitable | 60 m/min | H |
| INOX < 900 N/mm ² | suitable | 55 m/min | M |
| INOX > 900 N/mm ² | suitable | 50 m/min | M |
| Ti > 850 N/mm ² | suitable only under restricted conditions | 40 m/min | S |
| GG | suitable | 120 m/min | K |
| GGG | suitable | 80 m/min | K |

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