Garant

GARANT Master Steel FEED solid carbide drill, Weldon shank DIN 6535 HB, TiAlN, ⌀ DC h7: 9,1mm

Order data

Order number	123236 9,1
GTIN	4045197842961
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 12×D deep-hole drill, an initial centre drilling with an NC spotting drill No. 121130 with **155° point angle** is necessary.

Technical description

Feed f in steel < 1100 N/mm^2	0.44 mm/rev.
Tolerance nominal ⌀	h7
Overall length L	162 mm
Standard	Manufacturer's standard
Flute length L_c	120 mm
Number of cutting edges Z	3

Shank ⌀ D_s	10 mm
Nominal ⌀ D_C	9.1 mm
recommended maximum drilling depth L_2	106.4 mm
Series	Master Steel
Coating	TiAlN
Tool material	Solid carbide
Version	12×D
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/mm²	suitable	120 m/min	P
Steel < 750 N/mm²	suitable	110 m/min	P
Steel < 900 N/mm²	suitable	100 m/min	P
Steel < 1100 N/mm²	suitable	90 m/min	P
Steel < 1400 N/mm²	suitable	70 m/min	P
Steel < 55 HRC	suitable	60 m/min	H
INOX < 900 N/mm²	suitable	55 m/min	M
INOX > 900 N/mm²	suitable	50 m/min	M
Ti > 850 N/mm²	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