

## Garant

### GARANT Master Steel SPEED solid carbide drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 11mm



## Order data

|              |               |
|--------------|---------------|
| Order number | 123026 11     |
| GTIN         | 4045197846815 |
| Item class   | 11E           |

## Description

### Version:

Developed for use with **very high cutting speeds**. Outstandingly suitable for machines with **low installed power** and high speeds.

- **Clear reduction in cutting forces due to special cutter geometry.**
- **Coating for best wear resistance even at high process temperatures.**
- **Polished flutes for good chip clearance.**

A **slim chisel point** and the **special arrangement of the 4 guide chamfers** ensure **high positioning and alignment accuracy**. Optimised micro-geometry for increased working life and performance capability.

### Note:

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

## Technical description

|  |             |
|--|-------------|
| recommended maximum drilling depth $L_2$ | 97.5 mm     |
| Number of cutting edges Z                | 2           |
| Shank $\varnothing D_s$                  | 12 mm       |
| Overall length L                         | 162 mm      |
| Flute length $L_c$                       | 114 mm      |
| Feed f in steel < 1100 N/mm <sup>2</sup> | 0.2 mm/rev. |
| Nominal $\varnothing D_c$                | 11 mm       |
| Tolerance nominal $\varnothing$          | h7          |

|                    |                         |
|--------------------|-------------------------|
| Standard           | Manufacturer's standard |
| Series             | Master Steel            |
| Coating            | TiAlN                   |
| Tool material      | Solid carbide           |
| Version            | 8×D                     |
| Point angle        | 135 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                                  | 195 m/min      | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable                                  | 150 m/min      | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable                                  | 135 m/min      | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable                                  | 125 m/min      | P        |
| Steel < 1400 N/mm <sup>2</sup> | suitable                                  | 80 m/min       | P        |
| INOX < 900 N/mm <sup>2</sup>   | suitable only under restricted conditions | 65 m/min       | M        |
| GG                             | suitable                                  | 120 m/min      | K        |
| GGG                            | suitable                                  | 115 m/min      | K        |
| Uni                            | suitable                                  |                |          |
| wet maximum                    | suitable                                  |                |          |
| wet minimum                    | suitable                                  |                |          |