Garant

GARANT Master Steel FEED solid carbide drill, Weldon shank DIN 6535 HB, TiAlN, ⌀ DC h7: 11/32mm

Order data

Order number	122726 11/32
GTIN	4045197976222
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 operating 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.**
- **With 145° tip angle for low burr formation when drilling through holes.**

The **sector-leading technology of the chisel point** guarantees **optimum self-centring behaviour** and permits spot drilling on irregular surfaces. 3 guide chamfers guarantee a stable exit from the hole and an exact roundness of the hole.
Recommendation:
Maximum drilling depth:
flute length (see table) less 1.5×nominal ⌀.
Note:
Flute length $L_C = L_2 + 1.5 \times D_C$.
Standard: DIN 6537
Tolerance nominal ⌀: h7
Number of cutting edges Z: 2
Tolerance nominal ⌀: h7
recommended maximum drilling depth L_2: 47.905 mm
Overall length L: 103 mm
Shank ⌀ D_s: 10 mm
Feed f in steel < 1100 N/mm^2: 0.44 mm/rev.

Technical description

Overall length L	103 mm
Standard	DIN 6537
Flute length L_c	61 mm
Tolerance nominal ∅	h7
Number of cutting edges Z	2
Shank ∅ D_s	10 mm
Inch nominal ∅ corresponds to	8.73 mm
Feed f in steel < 1100 N/mm²	0.44 mm/rev.
recommended maximum drilling depth L_2	47.905 mm
Series	GARANT Master Steel
Coating	TiAlN
Tool material	solid carbide
	6×D
Point angle	145 °
Shank	DIN 6535 HB to h6
Through-coolant	yes, with 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	160 m/min	P
Steel < 750 N/mm²	suitable	140 m/min	P
Steel < 900 N/mm²	suitable	130 m/min	P
Steel < 1100 N/mm²	suitable	110 m/min	P
Steel < 1400 N/mm²	suitable	90 m/min	P
Steel < 55 HRC	suitable	60 m/min	H

INOX < 900 N/mm²	suitable	60 m/min	M
INOX > 900 N/mm²	suitable	50 m/min	M
GG	suitable	130 m/min	K
GGG	suitable	80 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable		