

**Garant**

**GARANT Master Steel FEED solid carbide drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 1/4 mm or inch**


**Order data**

Order number	122436 1/4
GTIN	4062406126896
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.**
- **With a 145° point angle for low burrs on emerging from 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:**

clamping slot length (see table) less 1.5×nominal Ø.

**Note:**

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

Machining strategy: HPC

Standard: DIN 6537 K

Tolerance nominal Ø: h7

Number of cutting edges Z: 3

Semi-Standard: yes

Tolerance nominal Ø: h7

recommended maximum drilling depth  $L_2$ : 24.475 mm

Overall length L: 79 mm

Shank Ø  $D_s$ : 8 mm

Feed f in steel < 1100 N/mm<sup>2</sup>: 0.37 mm/rev.

## Technical description

Inch nominal $\varnothing$ corresponds to	6.35 mm
Overall length L	79 mm
Feed f in steel < 1100 N/mm <sup>2</sup>	0.37 mm/rev.
Number of cutting edges Z	3
Shank $\varnothing D_s$	8 mm
Flute length L <sub>c</sub>	34 mm
recommended maximum drilling depth L <sub>2</sub>	24.475 mm
Standard	DIN 6537 K
Tolerance nominal $\varnothing$	h7
Semi-Standard	yes
Series	GARANT Master Steel
Coating	TiAlN
Tool material	solid carbide
Drill depth up to	4×D
Point angle	145 degrees
Shank	DIN 6535 HB to h6
Through-coolant	Yes, with 25 bar
Machining strategy	HPC
Colour ring	green
Type of product	Jobber drill