

Garant

GARANT Master Steel FEED solid carbide stepped drill, TiAlN, for threads: M12



Order data

Order number	125035 M12
GTIN	4062406066505
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.

Diameter tolerance first level: h7.

For generation of **optimum tapping holes**. Creates **ideal machining conditions** for the subsequent tapping tool. The cutter \varnothing of the drill is matched to the thread that is to be produced, in order to achieve a threads true to gauge and for **high process reliability of the tapping process**. The 90° counterbore for the thread is produced **in the same operation** as drilling the tapping hole.

Thread type: M

No. of teeth Z: 3

Through-coolant: yes, with 25 bar

Thread pitch: 1.75

$\varnothing D_1$ 1st step: 10.35 mm

$\varnothing D_2$ 2nd step with chamfer h7: 13.2 mm

Step height L_1 1st step: 30 mm

Flute length L_c : 60 mm

Overall length L: 107 mm

Technical description

Shank $\varnothing D_s$	14 mm
Flute length L_c	60 mm
$\varnothing D_2$ 2nd step with chamfer h7	13.2 mm
for threads	M12

Feed f in steel < 1100 N/mm ²	0.5 mm/rev.
Overall length L	107 mm
Thread pitch	1.75
Thread type	M
Through-coolant	yes, with 25 bar
No. of teeth Z	3
Ø D ₁ 1st step	10.35 mm
Step height L ₁ 1st step	30 mm
Series	GARANT Master Steel
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Tolerance nominal Ø	m7
Point angle	145 degrees
Shank	DIN 6535 HA to h6
Countersink angle	90 degrees
Machining strategy	HPC
Colour ring	green
Type of product	Stepped drill