

## Garant

### GARANT Master Steel FEED solid carbide stepped drill, TiAlN, for threads: M6



#### Order data

Order number	125035 M6
GTIN	4062406066451
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

$\varnothing D_1$  1st step: 5.1 mm

$\varnothing D_2$  2nd step with chamfer h7: 6.6 mm

Step height  $L_1$  1st step: 16.5 mm

Flute length  $L_c$ : 41 mm

Overall length L: 79 mm

#### Technical description

for threads	M6
Feed f in steel < 1100 N/mm <sup>2</sup>	0.32 mm/rev.
$\varnothing D_2$ 2nd step with chamfer h7	6.6 mm
Flute length $L_c$	41 mm

Overall length L	79 mm
Shank $\varnothing D_s$	8 mm
No. of teeth Z	3
Through-coolant	yes, with 25 bar
Thread type	M
Thread pitch	1
$\varnothing D_1$ 1st step	5.1 mm
Step height $L_1$ 1st step	16.5 mm
Series	GARANT Master Steel
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Tolerance nominal $\varnothing$	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