

Garant

GARANT Master Steel SPEED solid carbide drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 6,8 mm



Order data

Order number	122416 6,8
GTIN	4045197790392
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.

Recommendation:

Maximum drilling depth:

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

Note:

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

Standard: DIN 6537 K

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

Semi-Standard: yes

Tolerance nominal Ø: h7

recommended maximum drilling depth L_2 : 23.8 mm

Overall length L: 79 mm

Shank Ø D_s : 8 mm

Feed f in steel < 1100 N/mm²: 0.22 mm/rev.

Technical description

Feed f in steel < 1100 N/mm ²	0.22 mm/rev.
Nominal Ø D _c	6.8 mm
Flute length L _c	34 mm
Overall length L	79 mm
Shank tolerance	h6
Number of cutting edges Z	2
Shank Ø D _s	8 mm
Tolerance nominal Ø	h7
Standard	DIN 6537 K
recommended maximum drilling depth L ₂	23.8 mm
Semi-Standard	yes
Series	GARANT Master Steel
Coating	TiAlN
Tool material	solid carbide
Drill depth up to	4×D
Point angle	135 degrees
Shank	DIN 6535 HB to h6
Through-coolant	no
Machining strategy	HPC
Colour ring	green
Type of product	Jobber drill