## Garant

# GARANT Master Steel SPEED solid carbide drill, Weldon shank DIN 6535 HB, TIAIN, Ø DC h7: 11,7 mm



## Order data

| Order number | 122426 11,7   |
|--------------|---------------|
| GTIN         | 4045197792105 |
| 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  $1.5 \times nominal \emptyset$ .

#### 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 Tolerance nominal Ø: h7 recommended maximum drilling depth  $L_2$ : 37.5 mm Overall length L: 102 mm Shank Ø D<sub>s</sub>: 12 mm Feed f in steel < 1100 N/mm<sup>2</sup>: 0.28 mm/rev.

## **Technical description**

Number of cutting edges Z

2

| Tolerance nominal Øh7Nominal Ø Dc11.7 mmShank toleranceh6StandardDIN 6537 KFeed f in steel < 1100 N/mm²0.28 mm/rev.Overall length L102 mmFlute length Lc55 mmFecommended maximum drilling depth L237.5 mmSeriesGARANT Master SteelCoatingTiAINTool materialsolid carbideDrill depth up to4×DPoint angle1135 degreesShankDIN 6535 HB to h6Through-coolantYes, with 25 barMachining strategyHPCSemi-StandardyesColour ringgreen  | Shank Ø D <sub>s</sub>                   | 12 mm               |
|--|--|---------------------|
| Shank toleranceh6StandardDIN 6537 KFeed f in steel < 1100 N/mm²0.28 mm/rev.Overall length L102 mmFlute length L55 mmFeed maximum drilling depth L237.5 mmSeriesGARANT Master SteelCoatingTiAINTool materialsolid carbideDrill depth up to4×DPoint angle135 degreesShankDIN 6535 HB to h6Through-coolantYes, with 25 barMachining strategyyesColour ringgreen   | Tolerance nominal Ø                      | h7                  |
| StandardDIN 6537 KFeed f in steel < 1100 N/mm²0.28 mm/rev.Overall length L102 mmFlute length Lc55 mmrecommended maximum drilling depth L237.5 mmSeriesGARANT Master SteelCoatingTiAINTool materialSolid carbideDrill depth up to4×DPoint angle135 degreesShankDIN 6535 HB to h6Through-coolantYes, with 25 barMachining strategyHPCSemi-StandardyesColour ringgreen  | Nominal Ø D <sub>c</sub>                 | 11.7 mm             |
| Feed f in steel < 1100 N/mm²   | Shank tolerance                          | h6                  |
| Overall length L102 mmFlute length Lc55 mmrecommended maximum drilling depth L237.5 mmSeriesGARANT Master SteelCoatingTiAINTool materialSolid carbideDrill depth up to4×DPoint angle135 degreesShankDIN 6535 HB to h6Through-coolantYes, with 25 barMachining strategyHPCSemi-StandardyesColour ringgreen  | Standard                                 | DIN 6537 K          |
| Flute length L55 mmrecommended maximum drilling depth L237.5 mmSeriesGARANT Master SteelCoatingTiAINTool materialsolid carbideDrill depth up to4×DPoint angle135 degreesShankDIN 6535 HB to h6Through-coolantYes, with 25 barMachining strategyHPCSemi-StandardyesColour ringgreen   | Feed f in steel < 1100 N/mm <sup>2</sup> | 0.28 mm/rev.        |
| recommended maximum drilling depth L <sub>2</sub> 37.5 mm<br>Series GARANT Master Steel<br>Coating TiAlN<br>Tool material Solid carbide<br>Drill depth up to 4×D<br>Point angle 135 degrees<br>Shank DIN 6535 HB to h6<br>Through-coolant Yes, with 25 bar<br>Machining strategy HPC<br>Semi-Standard yes<br>Colour ring Garant Standard St | Overall length L                         | 102 mm              |
| SeriesGARANT Master SteelCoatingTiAINTool materialsolid carbideDrill depth up to4×DPoint angle135 degreesShankDIN 6535 HB to h6Through-coolantYes, with 25 barMachining strategyHPCSemi-StandardyesColour ringgreen  | Flute length L <sub>c</sub>              | 55 mm               |
| CoatingTiAINTool materialSolid carbideDrill depth up to4×DPoint angle135 degreesShankDIN 6535 HB to h6Through-coolantYes, with 25 barMachining strategyHPCSemi-StandardyesColour ringgreen   | recommended maximum drilling depth $L_2$ | 37.5 mm             |
| Tool materialsolid carbideDrill depth up to4×DPoint angle135 degreesShankDIN 6535 HB to h6Through-coolantYes, with 25 barMachining strategyHPCSemi-StandardyesColour ringgreen   | Series                                   | GARANT Master Steel |
| Drill depth up to4×DPoint angle135 degreesShankDIN 6535 HB to h6Through-coolantYes, with 25 barMachining strategyHPCSemi-StandardyesColour ringgreen   | Coating                                  | TiAlN               |
| Point angle135 degreesShankDIN 6535 HB to h6Through-coolantYes, with 25 barMachining strategyHPCSemi-StandardyesColour ringgreen   | Tool material                            | solid carbide       |
| ShankDIN 6535 HB to h6Through-coolantYes, with 25 barMachining strategyHPCSemi-StandardyesColour ringgreen   | Drill depth up to                        | 4×D                 |
| Through-coolantYes, with 25 barMachining strategyHPCSemi-StandardyesColour ringgreen   | Point angle                              | 135 degrees         |
| Machining strategyHPCSemi-StandardyesColour ringgreen  | Shank                                    | DIN 6535 HB to h6   |
| Semi-Standard yes   Colour ring green  | Through-coolant                          | Yes, with 25 bar    |
| Colour ring green  | Machining strategy                       | HPC                 |
|  | Semi-Standard                            | yes                 |
| Type of product Jobber drill   | Colour ring                              | green               |
| Type of product Jobbel diffi   | Type of product                          | Jobber drill        |