

## Garant

**GARANT Master Steel SPEED solid carbide drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 7,7 mm**



### Order data

|              |               |
|--------------|---------------|
| Order number | 122426 7,7    |
| GTIN         | 4045197791702 |
| 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

Tolerance nominal Ø: h7

recommended maximum drilling depth  $L_2$ : 29.5 mm

Overall length L: 79 mm

Shank Ø  $D_s$ : 8 mm

Feed f in steel < 1100 N/mm<sup>2</sup>: 0.22 mm/rev.

### Technical description

|                 |        |
|-----------------|--------|
| Nominal Ø $D_c$ | 7.7 mm |
|-----------------|--------|

|  |                     |
|--|---------------------|
| Standard                                 | DIN 6537 K          |
| Number of cutting edges Z                | 2                   |
| Shank tolerance                          | h6                  |
| Tolerance nominal $\varnothing$          | h7                  |
| Flute length $L_c$                       | 41 mm               |
| Shank $\varnothing D_s$                  | 8 mm                |
| Feed f in steel < 1100 N/mm <sup>2</sup> | 0.22 mm/rev.        |
| Overall length L                         | 79 mm               |
| recommended maximum drilling depth $L_2$ | 29.5 mm             |
| Series                                   | GARANT Master Steel |
| Coating                                  | TiAlN               |
| Tool material                            | solid carbide       |
| Drill depth up to                        | 4xD                 |
| Point angle                              | 135 degrees         |
| Shank                                    | DIN 6535 HB to h6   |
| Through-coolant                          | Yes, with 25 bar    |
| Machining strategy                       | HPC                 |
| Semi-Standard                            | yes                 |
| Colour ring                              | green               |
| Type of product                          | Jobber drill        |