

## Garant

**GARANT Master Steel SPEED solid carbide drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 8,5 mm**



### Order data

|              |               |
|--------------|---------------|
| Order number | 122426 8,5    |
| GTIN         | 4045197791788 |
| 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  $L_2$ : 34.3 mm

Overall length L: 89 mm

Shank Ø  $D_s$ : 10 mm

Feed  $f$  in steel < 1100 N/mm<sup>2</sup>: 0.26 mm/rev.

### Technical description

|          |            |
|----------|------------|
| Standard | DIN 6537 K |
|----------|------------|

|   |                     |
|---|---------------------|
| Overall length L                                  | 89 mm               |
| Shank $\varnothing D_s$                           | 10 mm               |
| Nominal $\varnothing D_c$                         | 8.5 mm              |
| Tolerance nominal $\varnothing$                   | h7                  |
| Number of cutting edges Z                         | 2                   |
| Feed f in steel < 1100 N/mm <sup>2</sup>          | 0.26 mm/rev.        |
| Flute length L <sub>c</sub>                       | 47 mm               |
| Shank tolerance                                   | h6                  |
| recommended maximum drilling depth L <sub>2</sub> | 34.3 mm             |
| 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                                   | Yes, with 25 bar    |
| Machining strategy                                | HPC                 |
| Semi-Standard                                     | yes                 |
| Colour ring                                       | green               |
| Type of product                                   | Jobber drill        |