Garant

GARANT Master Steel FEED solid carbide drill, Weldon shank DIN 6535 HB, TiAIN, Ø DC h7 (mm or inch): 10,8 mm or inch



Order data

Order number	122436 10,8
GTIN	4045197793133
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.

- Special cutter geometry with stable cutting edges and large clearance at the centre enables very high feed rates.
- The patented tip is optimised for chip flow and generates low cutting pressure with good chip breakage.
- $\cdot\,$ With a 145° point angle for low burrs on emerging from through holes.

The sector-leading technology of the chisel point guarantees optimum self-centring behaviour and permits spot drilling on irregular surfaces. 3 guide chamfers guarantee a stable exit from the hole and an exact roundness of the hole.

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: 3 Tolerance nominal Ø: h7 recommended maximum drilling depth L_2 : 38.8 mm Overall length L: 102 mm Shank Ø D_s: 12 mm Feed f in steel < 1100 N/mm²: 0.5 mm/rev.

Technical description

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Data sheet

Overall length L102 mmOverall length L0.5 mm/rev.Flute length L0.5 mm/rev.Flute length L55 mmNominal Ø Dc10.8 mmStandardDIN 6537 KShank Ø Ds12 mmrecommended maximum drilling depth L238.8 mmSeriesGARANT Master SteelCoatingTiAINTool materialsolid carbideDrill depth up to4×DPoint angle145 degreesShankDIN 6535 HB to h6Through-coolantYes, with 25 barMachining strategyHPCSemi-StandardyesColour ringgreen	Number of cutting edges Z	3
Feed f in steel < 1100 N/mm²0.5 mm/rev.Flute length Lc55 mmNominal Ø Dc10.8 mmStandardDIN 6537 KShank Ø D,12 mmrecommended maximum drilling depth L238.8 mmSeriesGARANT Master SteelCoatingTiAINTool materialsolid carbideDrill depth up to4×DPoint angle145 degreesShankDIN 6535 HB to h6Through-coolantYes, with 25 barMachining strategyHPCSemi-StandardyesColour ringgreen	Tolerance nominal Ø	h7
Flute length Lc55 mmNominal Ø Dc10.8 mmStandardDIN 6537 KShank Ø Ds12 mmrecommended maximum drilling depth L238.8 mmSeriesGARANT Master SteelCoatingTiAlNTool materialsolid carbideDrill depth up to4×DPoint angle145 degreesShankDIN 6535 HB to h6Through-coolantYes, with 25 barMachining strategyHPCSemi-StandardyesColour ringgreen	Overall length L	102 mm
Nominal Ø Dc10.8 mmStandardDIN 6537 KShank Ø Ds12 mmrecommended maximum drilling depth L238.8 mmSeriesGARANT Master SteelCoatingTiAINTool materialSolid carbideDrill depth up to4×DPoint angle145 degreesShankDIN 6535 HB to h6Through-coolantYes, with 25 barMachining strategyHPCSemi-StandardyesColour ringgreen	Feed f in steel < 1100 N/mm ²	0.5 mm/rev.
StandardDIN 6537 KShank Ø D,12 mmrecommended maximum drilling depth L238.8 mmSeriesGARANT Master SteelCoatingTiAINTool materialSolid carbideDrill depth up to4×DPoint angle145 degreesShankDIN 6535 HB to h6Through-coolantYes, with 25 barMachining strategyHPCSemi-StandardyesColour ringGreen	Flute length L _c	55 mm
Shank Ø D,12 mmrecommended maximum drilling depth L238.8 mmSeriesGARANT Master SteelCoatingTiAlNTool materialsolid carbideDrill depth up to4×DPoint angle145 degreesShankDIN 6535 HB to h6Through-coolantYes, with 25 barMachining strategyHPCSemi-StandardyesColour ringgreen	Nominal Ø D _c	10.8 mm
recommended maximum drilling depth L ₂ 38.8 mm Series GARANT Master Steel Coating TiAlN Tool material Solid carbide Drill depth up to 4×D Point angle 145 degrees Shank DIN 6535 HB to h6 Through-coolant Yes, with 25 bar Machining strategy HPC Semi-Standard yes Colour ring Green	Standard	DIN 6537 K
SeriesGARANT Master SteelCoatingTiAINTool materialsolid carbideDrill depth up to4×DPoint angle145 degreesShankDIN 6535 HB to h6Through-coolantYes, with 25 barMachining strategyHPCSemi-StandardyesColour ringgreen	Shank Ø D _s	12 mm
CoatingTiAlNTool materialSolid carbideDrill depth up to4×DPoint angle145 degreesShankDIN 6535 HB to h6Through-coolantYes, with 25 barMachining strategyHPCSemi-StandardyesColour ringgreen	recommended maximum drilling depth L_2	38.8 mm
Tool materialsolid carbideDrill depth up to4×DPoint angle145 degreesShankDIN 6535 HB to h6Through-coolantYes, with 25 barMachining strategyHPCSemi-StandardyesColour ringgreen	Series	GARANT Master Steel
Drill depth up to4×DPoint angle145 degreesShankDIN 6535 HB to h6Through-coolantYes, with 25 barMachining strategyHPCSemi-StandardyesColour ringgreen	Coating	TiAIN
Point angle145 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	145 degrees
Machining strategyHPCSemi-StandardyesColour ringgreen	Shank	DIN 6535 HB to h6
Semi-StandardyesColour ringgreen	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	Jobber drill