

Garant

GARANT Master Steel FEED solid carbide drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7 (mm or inch): 13,8 mm or inch



Order data

Order number	122436 13,8
GTIN	4045197793324
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.**
- **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 : 39.3 mm

Overall length L: 107 mm

Shank Ø D_s : 14 mm

Feed f in steel < 1100 N/mm²: 0.56 mm/rev.

Technical description

Feed f in steel < 1100 N/mm ²	0.56 mm/rev.
Tolerance nominal Ø	h7
Number of cutting edges Z	3
Standard	DIN 6537 K
Flute length L _c	60 mm
Nominal Ø D _c	13.8 mm
Shank Ø D _s	14 mm
Overall length L	107 mm
recommended maximum drilling depth L ₂	39.3 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
Type of product	Jobber drill