

## Garant

**GARANT Master Steel FEED solid carbide drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7 (mm or inch): 19,8 mm or inch**



### Order data

Order number	122436 19,8
GTIN	4045197793560
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  $L_2$ : 49.3 mm

Overall length L: 131 mm

Shank Ø  $D_s$ : 20 mm

Feed  $f$  in steel < 1100 N/mm<sup>2</sup>: 0.69 mm/rev.

### Technical description

Nominal $\varnothing D_c$	19.8 mm
Shank $\varnothing D_s$	20 mm
Tolerance nominal $\varnothing$	h7
Flute length $L_c$	79 mm
Standard	DIN 6537 K
Overall length $L$	131 mm
Feed $f$ in steel $< 1100 \text{ N/mm}^2$	0.69 mm/rev.
Number of cutting edges $Z$	3
recommended maximum drilling depth $L_2$	49.3 mm
Series	GARANT Master Steel
Coating	TiAlN
Tool material	solid carbide
Drill depth up to	4xD
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