

GARANT Master Steel FEED solid carbide drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7 (mm or inch): 5,1 mm or inch



Order data

Order number	122436 5,1
GTIN	4045197792563
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 $1.5 \times nominal \emptyset$.

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 L₂: 20.4 mm

Overall length L: 66 mm Shank Ø D.: 6 mm

Feed f in steel < 1100 N/mm²: 0.32 mm/rev.

Technical description

Feed f in steel < 1100 N/mm² Shank Ø D₅ Nominal Ø Dc Standard DIN 6537 K Tolerance nominal Ø Flute length L₅ Number of cutting edges Z recommended maximum drilling depth L₂ Series GARANT Master Steel Coating TiAlN Tool material Drill depth up to Point angle Shank DIN 6535 HB to h6 Through-coolant Machining strategy Semi-Standard Colour ring O.32 mm/rev. 6 mm Namme An maximum An Tool Material Solid carbide 145 degrees Shank DIN 6535 HB to h6 Through-coolant Machining strategy HPC Semi-Standard yes Colour ring Green	Overall length L	66 mm
Shank Ø D₀ 6 mm Nominal Ø D₀ 5.1 mm Standard DIN 6537 K Tolerance nominal Ø h7 Flute length L₀ 28 mm Number of cutting edges Z 3 recommended maximum drilling depth L₂ 20.4 mm Series GARANT Master Steel Coating TiAIN 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		
Nominal Ø D _C Standard DIN 6537 K Tolerance nominal Ø h7 Flute length L _c 28 mm Number of cutting edges Z recommended maximum drilling depth L₂ Series GARANT Master Steel Coating TiAIN Tool material Drill depth up to Point angle Shank DIN 6535 HB to h6 Through-coolant Machining strategy HPC Semi-Standard Colour ring 5.1 mm 5.1 mm 5.1 mm 5.1 mm 5.1 mm h7 h7 Aby Page mm Aby Page mm Aby BIN 6537 K DIN 6535 HB to h6 Through-coolant Yes, with 25 bar HPC Semi-Standard yes Colour ring Green	Feed f in steel < 1100 N/mm ²	0.32 mm/rev.
Standard DIN 6537 K Tolerance nominal Ø h7 Flute length L _c 28 mm Number of cutting edges Z 3 recommended maximum drilling depth L₂ 20.4 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	Shank Ø D₅	6 mm
Tolerance nominal \varnothing h7Flute length L_c 28 mmNumber of cutting edges Z3recommended maximum drilling depth L_2 20.4 mmSeriesGARANT Master SteelCoatingTiAINTool materialsolid carbideDrill depth up to $4 \times D$ Point angle 145 degreesShankDIN 6535 HB to h6Through-coolantYes, with 25 barMachining strategyHPCSemi-StandardyesColour ringgreen	Nominal Ø D _c	5.1 mm
Flute length L _c Number of cutting edges Z recommended maximum drilling depth L ₂ Series GARANT Master Steel Coating TiAIN Tool material Drill depth up to Point angle Shank DIN 6535 HB to h6 Through-coolant Machining strategy Semi-Standard Colour ring 128 mm 28 mm 28 mm Ann Ann Ann Ann Ann Ann Ann	Standard	DIN 6537 K
Number of cutting edges Z recommended maximum drilling depth L ₂ 20.4 mm Series GARANT Master Steel Coating TiAIN Tool material Solid carbide Drill depth up to 4×D Point angle Shank DIN 6535 HB to h6 Through-coolant Yes, with 25 bar Machining strategy HPC Semi-Standard yes Colour ring GRRANT Master Steel 1410 TiAIN Tool material Solid carbide 145 degrees 145 deg	Tolerance nominal Ø	h7
recommended maximum drilling depth L2 20.4 mm Series GARANT Master Steel TiAIN Tool material Drill depth up to Point angle Shank DIN 6535 HB to h6 Through-coolant Machining strategy HPC Semi-Standard Colour ring 20.4 mm 20.4 mm 20.4 mm Aux D Aux D TiAIN Solid carbide 4×D 145 degrees DIN 6535 HB to h6 Yes, with 25 bar HPC yes	Flute length L _c	28 mm
Series GARANT Master Steel Coating TiAIN 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	Number of cutting edges Z	3
Coating TiAIN 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	recommended maximum drilling depth L ₂	20.4 mm
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	Series	GARANT Master Steel
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	Coating	TiAIN
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	Tool material	solid carbide
Shank DIN 6535 HB to h6 Yes, with 25 bar Machining strategy HPC Semi-Standard yes Colour ring green	Drill depth up to	4×D
Through-coolant Machining strategy HPC Semi-Standard yes Colour ring green	Point angle	145 degrees
Machining strategy Semi-Standard Colour ring HPC yes green	Shank	DIN 6535 HB to h6
Semi-Standard yes Colour ring green	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