

## Garant

**GARANT Master Steel FEED solid carbide drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7 (mm or inch): 7,1 mm or inch**



### Order data

|              |               |
|--------------|---------------|
| Order number | 122436 7,1    |
| GTIN         | 4045197792761 |
| 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  $L_2$ : 30.4 mm

Overall length L: 79 mm

Shank Ø  $D_s$ : 8 mm

Feed  $f$  in steel < 1100 N/mm<sup>2</sup>: 0.37 mm/rev.

### Technical description

|   |                     |
|---|---------------------|
| Tolerance nominal $\varnothing$                   | h7                  |
| Nominal $\varnothing D_c$                         | 7.1 mm              |
| Standard  | DIN 6537 K          |
| Feed f in steel < 1100 N/mm <sup>2</sup>          | 0.37 mm/rev.        |
| Number of cutting edges Z                         | 3                   |
| Overall length L                                  | 79 mm               |
| Flute length L <sub>c</sub>                       | 41 mm               |
| Shank $\varnothing D_s$                           | 8 mm                |
| recommended maximum drilling depth L <sub>2</sub> | 30.4 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               |
| Type of product                                   | Jobber drill        |