

GARANT Master Steel FEED solid carbide drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7 (mm or inch): 9,5 mm or inch



Order data

Order number	122436 9,5
GTIN	4045197793003
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: 32.8 mm

Overall length L: 89 mm Shank Ø D_s: 10 mm

Feed f in steel < 1100 N/mm²: 0.44 mm/rev.

Technical description

Standard DIN 6537 K Overall length L 89 mm Flute length L₂ 47 mm Feed f in steel < 1100 N/mm² 0.44 mm/rev. Number of cutting edges Z 3 Tolerance nominal Ø h7 Nominal Ø D₂ 9.5 mm Shank Ø D₃ 10 mm recommended maximum drilling depth L₂ 32.8 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 Type of product Jobber drill		
Flute length L_c 47 mm Feed f in steel < 1100 N/mm² 0.44 mm/rev. Number of cutting edges Z 3 Tolerance nominal Ø h7 Nominal Ø D_c 9.5 mm Shank Ø D_s 10 mm recommended maximum drilling depth L_2 32.8 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
Feed f in steel < 1100 N/mm² Number of cutting edges Z Tolerance nominal Ø Nominal Ø Dc Shank Ø D₃ 10 mm 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 O.44 mm/rev. 3 0.44 mm/rev. 3 A Brian And Application Applica	Overall length L	89 mm
Number of cutting edges Z 3 Tolerance nominal \varnothing h7 Nominal \varnothing D _c 9.5 mm Shank \varnothing D _s 10 mm recommended maximum drilling depth L ₂ 32.8 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	Flute length L _c	47 mm
Tolerance nominal \varnothing h7 Nominal \varnothing Dc 9.5 mm Shank \varnothing Ds 10 mm recommended maximum drilling depth L2 32.8 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	Feed f in steel < 1100 N/mm ²	0.44 mm/rev.
Nominal \varnothing Dc9.5 mmShank \varnothing Ds10 mmrecommended maximum drilling depth L232.8 mmSeriesGARANT Master SteelCoatingTiAINTool materialsolid carbideDrill depth up to $4 \times D$ Point angle145 degreesShankDIN 6535 HB to h6Through-coolantYes, with 25 barMachining strategyHPCSemi-StandardyesColour ringgreen	Number of cutting edges Z	3
Shank Ø D₅ 10 mm recommended maximum drilling depth L₂ 32.8 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	Tolerance nominal Ø	h7
recommended maximum drilling depth L2 32.8 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	9.5 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	Shank Ø D _s	10 mm
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	32.8 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 HPC Semi-Standard yes Colour ring 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