

Garant

GARANT Master Steel FEED solid carbide drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 3/16 mm


Order data

Order number	122726 3/16
GTIN	4045197976178
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 operating 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 145° tip angle for low burr formation when drilling 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:

flute length (see table) less 1.5×nominal Ø.

Note:

Flute length $L_c = L_2 + 1.5 \times D_c$

Machining strategy: HPC

Standard: DIN 6537

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

Semi-Standard: yes

Tolerance nominal Ø: h7

recommended maximum drilling depth L_2 : 36.86 mm

Overall length L: 82 mm

Shank Ø D_s : 6 mm

Feed f in steel < 1100 N/mm²: 0.28 mm/rev.

Technical description

Number of cutting edges Z	2
recommended maximum drilling depth L ₂	36.86 mm
Standard	DIN 6537
Flute length L _c	44 mm
Tolerance nominal Ø	h7
Feed f in steel < 1100 N/mm ²	0.28 mm/rev.
Overall length L	82 mm
Inch nominal Ø corresponds to	4.76 mm
Shank Ø D _s	6 mm
Semi-Standard	yes
Series	GARANT Master Steel
Coating	TiAlN
Tool material	solid carbide
Drill depth up to	6×D
Point angle	145 degrees
Shank	DIN 6535 HB to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Colour ring	green
Type of product	Jobber drill