

# GARANT Master Steel FEED solid carbide drill, Weldon shank DIN 6535 HB, TiAIN, Ø DC h7: 8 mm



#### Order data

| Order number | 1227268       |
|--------------|---------------|
| GTIN         | 4045197795199 |
| 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  $1.5 \times \text{nominal } \emptyset$ .

#### Note:

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

Standard: DIN 6537 Tolerance nominal Ø: h7 Number of cutting edges Z: 3

recommended maximum drilling depth L<sub>2</sub>: 41 mm

Overall length L: 91 mm Shank  $\varnothing$  D<sub>s</sub>: 8 mm

Tolerance nominal Ø: h7

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

# **Technical description**

| Tolerance nominal Ø Shank Ø D₃ Shank Ø D₃ Flute length L₂ Standard Nominal Ø D₂ Standard DIN 6537 Overall length L Number of cutting edges Z Feed f in steel < 1100 N/mm² Oseries GARANT Master Steel Coating TiAlN Tool material Solid carbide Drill depth up to Point angle Shank DIN 6535 HB to h6 Through-coolant Machining strategy HPC Semi-Standard Colour ring Type of product  Samm Samm Samm Samm Samm Samm Samm Sa  |   |                     |
|--|---|---------------------|
| Flute length L₂ 53 mm  Nominal Ø D₂ 8 mm  Standard DIN 6537  Overall length L 91 mm  Number of cutting edges Z 3  Feed f in steel < 1100 N/mm² 0.37 mm/rev.  recommended maximum drilling depth L₂ 41 mm  Series GARANT Master Steel  Coating TiAIN  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  Semi-Standard yes  Colour ring green  | Tolerance nominal Ø                               | h7                  |
| Nominal Ø D <sub>c</sub> Standard  DIN 6537  Overall length L  Peed f in steel < 1100 N/mm²  Feed f in steel < 1100 N/mm²  Percommended 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  Coverall length L₂  Semi-Standard  DIN 6537  Semi-Standard  DIN 6537  Be mm  8 mm  8 mm  8 mm  8 mm  Point 6537  At mm  At mm  Series  GARANT Master Steel  GARANT Master Steel  TiAIN  Toll actricle  TiAIN  Solid carbide  Drill depth up to  A×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 <sub>s</sub>                            | 8 mm                |
| Standard DIN 6537  Overall length L 91 mm  Number of cutting edges Z 3  Feed f in steel < 1100 N/mm² 0.37 mm/rev.  recommended maximum drilling depth L₂ 41 mm  Series GARANT Master Steel  Coating TiAIN  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  Semi-Standard yes  Colour ring green  | Flute length L <sub>c</sub>                       | 53 mm               |
| Overall length L  Number of cutting edges Z  Feed f in steel < 1100 N/mm²  O.37 mm/rev.  recommended maximum drilling depth L₂  41 mm  Series  GARANT Master Steel  Coating  TiAIN  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  Semi-Standard  yes  Colour ring  green   | Nominal Ø D <sub>c</sub>                          | 8 mm                |
| Number of cutting edges Z  Feed f in steel < 1100 N/mm²  Recommended maximum drilling depth L₂  Feries  GARANT Master Steel  Coating  TiAIN  Tool material  Drill depth up to  Foint angle  Shank  DIN 6535 HB to h6  Through-coolant  Machining strategy  HPC  Semi-Standard  Co.37 mm/rev.  41 mm  GARANT Master Steel  TiAIN  Tool material  Solid carbide  6×D  Point angle  145 degrees  DIN 6535 HB to h6  Through-coolant  Yes, with 25 bar  HPC  Semi-Standard  Yes  Colour ring  Green  | Standard  | DIN 6537            |
| Feed f in steel < 1100 N/mm²  recommended maximum drilling depth L₂  41 mm  Series  GARANT Master Steel  Coating  TiAIN  Tool material  Solid carbide  Drill depth up to  Point angle  Shank  DIN 6535 HB to h6  Through-coolant  Machining strategy  HPC  Semi-Standard  yes  Colour ring  0.37 mm/rev.  41 mm  6xD  FIND  FOAR TIAIN  TiAIN  Tool material  Solid carbide  EXD  FOAR TIAIN  TiAIN  Tool material  Solid carbide  EXD  FOAR TIAIN  TiAIN  Tool material  Solid carbide  EXD  FOAR TIAIN  FOAR TIAIN  THE COOL TIAIN  THE COOL TIAIN  TIAIN  TOOL TIAIN  TOOL TIAIN  TOOL TIAIN  THE COOL TIAIN  TOOL TIAIN  TOOL TIAIN  TIAIN  TOOL TIAIN  TOOL TIAIN  TOOL TIAIN  TOOL TIAIN  TOOL TIAIN  TI | Overall length L                                  | 91 mm               |
| recommended maximum drilling depth L2 41 mm  Series GARANT Master Steel  Coating TiAIN  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  Semi-Standard yes  Colour ring green   | Number of cutting edges Z                         | 3                   |
| Series GARANT Master Steel  Coating TiAIN  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  Semi-Standard yes  Colour ring green  | Feed f in steel < 1100 N/mm <sup>2</sup>          | 0.37 mm/rev.        |
| CoatingTiAINTool materialsolid carbideDrill depth up to6×DPoint angle145 degreesShankDIN 6535 HB to h6Through-coolantyes, with 25 barMachining strategyHPCSemi-StandardyesColour ringgreen   | recommended maximum drilling depth L <sub>2</sub> | 41 mm               |
| 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  Semi-Standard yes  Colour ring green   | Series  | GARANT Master Steel |
| 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  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  Through-coolant  Machining strategy  HPC  Semi-Standard  yes  Colour ring  green   | Drill depth up to                                 | 6×D                 |
| Through-coolant yes, with 25 bar  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        |