Garant

GARANT Master Steel FEED solid carbide drill, Weldon shank DIN 6535 HB, TiAIN, Ø DC h7: 9,9 mm

Order data

Order number	122726 9,9
GTIN	4045197795380
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 $1.5 \times nominal \emptyset$.

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 Tolerance nominal Ø: h7 recommended maximum drilling depth L_2 : 46.2 mm Overall length L: 103 mm Shank Ø D_s: 10 mm Feed f in steel < 1100 N/mm²: 0.44 mm/rev.

Technical description

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Data sheet

Nominal Ø Dc9.9 mmOverall length L103 mmFlute length Lc61 mmTolerance nominal Øh7Shank Ø D,100 mmNumber of cutting edges Z3recommended maximum drilling depth L246.2 mmSeriesGARANT Master SteelCoatingTiAINTool materialsolid carbideDrill depth up to6×DPoint angle145 degreesShankDIN 6535 HB to h6Through-coolantyesMachining strategyHPCSemi-StandardyesGlour ringgreen	Standard	DIN 6537
Overall length L103 mmFlute length L61 mmFlute length L61 mmTolerance nominal Øh7Shank Ø D,10 mmNumber of cutting edges Z3recommended maximum drilling depth L246.2 mmSeriesGARANT Master SteelCoatingTiAINTool materialsolid carbideDrill depth up to6×DPoint angle145 degreesShankDIN 6535 HB to h6Through-coolantyes, with 25 barMachining strategyHPCSemi-StandardyesColour ringgreen	Feed f in steel < 1100 N/mm ²	0.44 mm/rev.
Flute length L,61 mmTolerance nominal Øh7Shank Ø D,10 mmNumber of cutting edges Z3recommended maximum drilling depth L246.2 mmSeriesGARANT Master SteelCoatingTiAINTool materialSolid carbideDrill depth up to6×DPoint angle145 degreesShankDIN 6535 HB to h6Through-coolantyes, with 25 barMachining strategyHPCSemi-StandardyesColour ringgreen	Nominal Ø D _c	9.9 mm
Tolerance nominal Øh7Shank Ø Ds10 mmNumber of cutting edges Z3recommended maximum drilling depth L246.2 mmSeriesGARANT Master SteelCoatingTiAINTool materialsolid carbideDrill depth up to6×DPoint angle145 degreesShankDIN 6535 HB to h6Through-coolantyes, with 25 barMachining strategyHPCSemi-StandardyesColour ringgreen	Overall length L	103 mm
Shank Ø D,10 mmNumber of cutting edges Z3recommended maximum drilling depth L246.2 mmSeriesGARANT Master SteelCoatingTiAINTool materialSolid carbideDrill depth up to6×DPoint angle145 degreesShankDIN 6535 HB to h6Through-coolantyes, with 25 barMachining strategyHPCSemi-StandardyesColour ringgreen	Flute length L _c	61 mm
Number of cutting edges Z3recommended maximum drilling depth L246.2 mmSeriesGARANT Master SteelCoatingTiAINTool materialsolid carbideDrill depth up to6×DPoint angle145 degreesShankDIN 6535 HB to h6Through-coolantyes, with 25 barMachining strategyHPCSemi-StandardyesColour ringgreen	Tolerance nominal Ø	h7
recommended maximum drilling depth L ₂ 46.2 mm 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 Semi-Standard Yes Colour ring Green	Shank Ø D _s	10 mm
SeriesGARANT Master SteelCoatingTiAINTool materialsolid carbideDrill depth up to6×DPoint angle145 degreesShankDIN 6535 HB to h6Through-coolantyes, with 25 barMachining strategyHPCSemi-StandardyesColour ringgreen	Number of cutting edges Z	3
CoatingTiAINTool materialSolid carbideDrill depth up to $6 \times D$ Point angle145 degreesShankDIN 6535 HB to h6Through-coolantyes, with 25 barMachining strategyHPCSemi-StandardyesColour ringgreen	recommended maximum drilling depth L_2	46.2 mm
Tool materialsolid carbideDrill depth up to6×DPoint angle145 degreesShankDIN 6535 HB to h6Through-coolantyes, with 25 barMachining strategyHPCSemi-StandardyesColour ringgreen	Series	GARANT Master Steel
Drill depth up to6×DPoint angle145 degreesShankDIN 6535 HB to h6Through-coolantyes, with 25 barMachining strategyHPCSemi-StandardyesColour ringgreen	Coating	TiAIN
Point angle145 degreesShankDIN 6535 HB to h6Through-coolantyes, with 25 barMachining strategyHPCSemi-StandardyesColour ringgreen	Tool material	solid carbide
ShankDIN 6535 HB to h6Through-coolantyes, with 25 barMachining strategyHPCSemi-StandardyesColour ringgreen	Drill depth up to	6×D
Through-coolantyes, with 25 barMachining strategyHPCSemi-StandardyesColour ringgreen	Point angle	145 degrees
Machining strategyHPCSemi-StandardyesColour ringgreen	Shank	DIN 6535 HB to h6
Semi-StandardyesColour ringgreen	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 unit	Type of product	Jobber drill