

# GARANT Master Steel FEED solid carbide drill, Weldon shank DIN 6535 HB, TiAIN, Ø DC h7: 11,6 mm



## Order data

Order number	123036 11,6
GTIN	4045197842091
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.

The sector-leading technology of the drill point guarantees optimum self-centring behaviour. 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  $1.5 \times \text{nominal } \emptyset$ .

#### Note:

Flute length  $L_c = L_2 + 1.5 \times D_c$ . Standard: Manufacturer's standard

Tolerance nominal Ø: h7 Number of cutting edges Z: 3 Tolerance nominal Ø: h7

recommended maximum drilling depth L₂: 96.6 mm

Overall length L: 162 mm Shank Ø D<sub>s</sub>: 12 mm

Feed f in steel < 1100 N/mm<sup>2</sup>: 0.5 mm/rev.

# **Technical description**



Overall length L162 mmFeed f in steel < 1100 N/mm²0.5 mm/rev.Shank Ø D₂12 mmStandardManufacturer's standardNominal Ø D₂11.6 mmrecommended maximum drilling depth L₂96.6 mmTolerance nominal Øh7Flute length L₂114 mmNumber of cutting edges Z3SeriesGARANT Master SteelCoatingTiAINTool materialSolid carbideDrill depth up to8×DPoint angle140 degreesShankDIN 6535 HB to h6Through-coolantyes, to 25 barMachining strategyHPCSemi-StandardyesColour ringgreenType of productJobber drill		
Shank Ø D₅       12 mm         Standard       Manufacturer's standard         Nominal Ø Dc       11.6 mm         recommended maximum drilling depth L₂       96.6 mm         Tolerance nominal Ø       h7         Flute length Lҫ       114 mm         Number of cutting edges Z       3         Series       GARANT Master Steel         Coating       TiAlN         Tool material       Solid carbide         Drill depth up to       8×D         Point angle       140 degrees         Shank       DIN 6535 HB to h6         Through-coolant       yes, to 25 bar         Machining strategy       HPC         Semi-Standard       yes         Colour ring       green	Overall length L	162 mm
$\begin{array}{cccccccccccccccccccccccccccccccccccc$	Feed f in steel < 1100 N/mm <sup>2</sup>	0.5 mm/rev.
Nominal Ø Dc       11.6 mm         recommended maximum drilling depth L₂       96.6 mm         Tolerance nominal Ø       h7         Flute length Lc       114 mm         Number of cutting edges Z       3         Series       GARANT Master Steel         Coating       TiAIN         Tool material       Solid carbide         Drill depth up to       8×D         Point angle       140 degrees         Shank       DIN 6535 HB to h6         Through-coolant       yes, to 25 bar         Machining strategy       HPC         Semi-Standard       yes         Colour ring       green	Shank Ø D₅	12 mm
recommended maximum drilling depth L2 96.6 mm  Tolerance nominal Ø h7  Flute length L2 114 mm  Number of cutting edges Z 3  Series GARANT Master Steel  Coating TiAIN  Tool material Solid carbide  Drill depth up to 8×D  Point angle 140 degrees  Shank DIN 6535 HB to h6  Through-coolant yes, to 25 bar  Machining strategy HPC  Semi-Standard yes  Colour ring green	Standard	Manufacturer's standard
Tolerance nominal Ø h7  Flute length L₂ 114 mm  Number of cutting edges Z 3  Series GARANT Master Steel  Coating TiAIN  Tool material Solid carbide  Drill depth up to 8×D  Point angle 140 degrees  Shank DIN 6535 HB to h6  Through-coolant yes, to 25 bar  Machining strategy HPC  Semi-Standard yes  Colour ring green	Nominal Ø D <sub>c</sub>	11.6 mm
Flute length L <sub>c</sub> Number of cutting edges Z  Series  GARANT Master Steel  Coating  TiAlN  Tool material  Solid carbide  Drill depth up to  8×D  Point angle  140 degrees  Shank  DIN 6535 HB to h6  Through-coolant  yes, to 25 bar  Machining strategy  HPC  Semi-Standard  yes  Colour ring  green	recommended maximum drilling depth L <sub>2</sub>	96.6 mm
Number of cutting edges Z  Series  GARANT Master Steel  Coating  TiAIN  Tool material  Solid carbide  Drill depth up to  8×D  Point angle  140 degrees  Shank  DIN 6535 HB to h6  Through-coolant  yes, to 25 bar  Machining strategy  HPC  Semi-Standard  yes  Colour ring  green	Tolerance nominal Ø	h7
Series GARANT Master Steel  Coating TiAIN  Tool material Solid carbide  Drill depth up to 8×D  Point angle 140 degrees  Shank DIN 6535 HB to h6  Through-coolant yes, to 25 bar  Machining strategy HPC  Semi-Standard yes  Colour ring green	Flute length L <sub>c</sub>	114 mm
CoatingTiAINTool materialSolid carbideDrill depth up to8×DPoint angle140 degreesShankDIN 6535 HB to h6Through-coolantyes, to 25 barMachining strategyHPCSemi-StandardyesColour ringgreen	Number of cutting edges Z	3
Tool material  Drill depth up to  8×D  Point angle  140 degrees  Shank  DIN 6535 HB to h6  Through-coolant  Machining strategy  HPC  Semi-Standard  yes  Colour ring  Solid carbide  8×D  140 degrees  1	Series	GARANT Master Steel
Drill depth up to 8×D  Point angle 140 degrees  Shank DIN 6535 HB to h6  Through-coolant yes, to 25 bar  Machining strategy HPC  Semi-Standard yes  Colour ring green	Coating	TiAIN
Point angle 140 degrees  Shank DIN 6535 HB to h6  Through-coolant yes, to 25 bar  Machining strategy HPC  Semi-Standard yes  Colour ring green	Tool material	Solid carbide
Shank DIN 6535 HB to h6  Through-coolant yes, to 25 bar  Machining strategy HPC  Semi-Standard yes  Colour ring green	Drill depth up to	8×D
Through-coolant yes, to 25 bar  Machining strategy HPC  Semi-Standard yes  Colour ring green	Point angle	140 degrees
Machining strategy  Semi-Standard  yes  Colour ring  green	Shank	DIN 6535 HB to h6
Semi-Standard yes Colour ring green	Through-coolant	yes, to 25 bar
Colour ring green	Machining strategy	HPC
-	Semi-Standard	yes
Type of product Jobber drill	Colour ring	green
	Type of product	Jobber drill