

GARANT Master Steel FEED solid carbide drill, Weldon shank DIN 6535 HB, TiAIN, Ø DC h7: 19,2 mm



Order data

Order number	123036 19,2
GTIN	4045197842428
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: 161.2 mm

Overall length L: 243 mm Shank Ø D₆: 20 mm

Feed f in steel < 1100 N/mm²: 0.69 mm/rev.

Technical description

Iolerance nominal Ø h7 Overall length L 243 mm Number of cutting edges Z 3 Shank Ø D₂ 20 mm Feed f in steel < 1100 N/mm² 0.69 mm/rev. recommended maximum drilling depth L₂ 161.2 mm Standard Manufacturer's standard Flute length L₂ 190 mm Nominal Ø D₂ 19.2 mm 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 Type of product Jobber drill	- 1	
Number of cutting edges Z Shank Ø D₁ Feed f in steel < 1100 N/mm² 7	Tolerance nominal Ø	h7
Shank Ø D₃ 20 mm Feed f in steel < 1100 N/mm²	Overall length L	243 mm
Feed f in steel < 1100 N/mm² recommended maximum drilling depth L₂ 161.2 mm Standard Manufacturer's standard Flute length L₂ 190 mm Nominal Ø D₂ Series GARANT Master Steel Coating TiAlN Tool material Solid carbide Drill depth up to 8×D Point angle Shank DIN 6535 HB to h6 Through-coolant Machining strategy HPC Semi-Standard yes Colour ring green	Number of cutting edges Z	3
recommended maximum drilling depth L2 161.2 mm Standard Manufacturer's standard Flute length L2 190 mm Nominal Ø D2 19.2 mm 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 D _s	20 mm
StandardManufacturer's standardFlute length L₂190 mmNominal Ø D₂19.2 mmSeriesGARANT Master SteelCoatingTiAINTool materialSolid carbideDrill depth up to8×DPoint angle140 degreesShankDIN 6535 HB to h6Through-coolantyes, to 25 barMachining strategyHPCSemi-StandardyesColour ringgreen	Feed f in steel < 1100 N/mm ²	0.69 mm/rev.
Flute length L _c 190 mm Nominal Ø D _C 19.2 mm 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	recommended maximum drilling depth L ₂	161.2 mm
Nominal Ø D _c 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 Machining strategy HPC Semi-Standard yes Colour ring 19.2 mm 19.2	Standard	Manufacturer's standard
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 _c	190 mm
CoatingTiAINTool materialSolid carbideDrill depth up to8×DPoint angle140 degreesShankDIN 6535 HB to h6Through-coolantyes, to 25 barMachining strategyHPCSemi-StandardyesColour ringgreen	Nominal Ø D _c	19.2 mm
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 140 degrees HPC yes, to 25 bar HPC	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 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 HPC 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