

## Garant

**GARANT Master Steel FEED solid carbide drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7: 8,6 mm**



### Order data

Order number	123235 8,6
GTIN	4045197840677
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.**

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:

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

##### Note:

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

For process reliability when using the 12×D drill, an initial centre drilling with an NC spotting drill No. 121130 with **155° point angle** is necessary.

Standard: Manufacturer's standard

Tolerance nominal Ø: h7

Number of cutting edges Z: 3

Tolerance nominal Ø: h7

recommended maximum drilling depth  $L_2$ : 107.1 mm

Overall length L: 162 mm

Shank Ø  $D_s$ : 10 mm

Feed  $f$  in steel < 1100 N/mm<sup>2</sup>: 0.44 mm/rev.

### Technical description

Shank $\varnothing D_s$	10 mm
Standard	Manufacturer's standard
Flute length $L_c$	120 mm
Overall length $L$	162 mm
Nominal $\varnothing D_c$	8.6 mm
Tolerance nominal $\varnothing$	h7
recommended maximum drilling depth $L_2$	107.1 mm
Feed $f$ in steel $< 1100 \text{ N/mm}^2$	0.44 mm/rev.
Number of cutting edges $Z$	3
Series	GARANT Master Steel
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	12xD
Point angle	140 degrees
Shank	DIN 6535 HA to h6
Through-coolant	yes, to 25 bar
Machining strategy	HPC
Semi-Standard	yes
Colour ring	green
Type of product	Jobber drill

## Services

Shank grinding Type HE	129100 HE
------------------------	-----------