

## Garant

### GARANT Master Steel FEED solid carbide drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7: 8,9 mm



## Order data

|              |               |
|--------------|---------------|
| Order number | 123235 8,9    |
| GTIN         | 4045197840707 |
| 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  $L_2$ : 106.7 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

|  |                         |
|--|-------------------------|
| Flute length $L_c$                       | 120 mm                  |
| Number of cutting edges Z                | 3                       |
| Nominal $\varnothing D_c$                | 8.9 mm                  |
| Standard                                 | Manufacturer's standard |
| Feed f in steel < 1100 N/mm <sup>2</sup> | 0.44 mm/rev.            |
| Shank $\varnothing D_s$                  | 10 mm                   |
| Overall length L                         | 162 mm                  |
| Tolerance nominal $\varnothing$          | h7                      |
| recommended maximum drilling depth $L_2$ | 106.7 mm                |
| 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 |
|------------------------|-----------|