

## Garant

**GARANT Master Steel FEED solid carbide drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 13,8 mm**



### Order data

Order number	123236 13,8
GTIN	4045197843326
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×nominal Ø.

##### Note:

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

For process reliability when using the 12×D deep-hole 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  $L_2$ : 161.3 mm

Overall length L: 230 mm

Shank Ø  $D_s$ : 14 mm

Feed  $f$  in steel < 1100 N/mm<sup>2</sup>: 0.56 mm/rev.

### Technical description

Feed f in steel < 1100 N/mm <sup>2</sup>	0.56 mm/rev.
Number of cutting edges Z	3
Nominal Ø D <sub>c</sub>	13.8 mm
Tolerance nominal Ø	h7
Shank Ø D <sub>s</sub>	14 mm
recommended maximum drilling depth L <sub>2</sub>	161.3 mm
Standard	Manufacturer's standard
Overall length L	230 mm
Flute length L <sub>c</sub>	182 mm
Series	GARANT Master Steel
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	12×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