

## Garant

**GARANT Master Steel FEED solid carbide drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 18 mm**



### Order data

Order number	123236 18
GTIN	4045197843494
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  $L_2$ : 207 mm

Overall length L: 285 mm

Shank Ø  $D_s$ : 18 mm

Feed  $f$  in steel < 1100 N/mm<sup>2</sup>: 0.66 mm/rev.

### Technical description

Tolerance nominal $\varnothing$	h7
Overall length L	285 mm
Flute length $L_c$	234 mm
recommended maximum drilling depth $L_2$	207 mm
Nominal $\varnothing D_c$	18 mm
Feed f in steel < 1100 N/mm <sup>2</sup>	0.66 mm/rev.
Number of cutting edges Z	3
Standard	Manufacturer's standard
Shank $\varnothing D_s$	18 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