

Garant

GARANT Master Steel FEED solid carbide drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 19,8 mm



Order data

Order number	123236 19,8
GTIN	4045197843562
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 : 228.3 mm

Overall length L: 310 mm

Shank Ø D_s : 20 mm

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

Technical description

Overall length L	310 mm
Shank $\varnothing D_s$	20 mm
Flute length L_c	258 mm
Nominal $\varnothing D_c$	19.8 mm
Feed f in steel < 1100 N/mm ²	0.69 mm/rev.
recommended maximum drilling depth L_2	228.3 mm
Number of cutting edges Z	3
Tolerance nominal \varnothing	h7
Standard	Manufacturer's standard
Series	GARANT Master Steel
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	12xD
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