ⓘ Hoffmann Group

Garant

GARANT Master Steel FEED solid carbide drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 6,1 mm

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Order data

Order number	123236 6,1
GTIN	4045197842664
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: 98.9 mm
Overall length L: 146 mm
Shank Ø D_s: 8 mm
Feed f in steel < 1100 N/mm^2: 0.37 mm/rev.

Technical description

Nominal Ø D_c	6.1 mm
Tolerance nominal Ø	h7
Number of cutting edges Z	3
recommended maximum drilling depth L_2	98.9 mm
Feed f in steel < 1100 N/mm^2	0.37 mm/rev.
Overall length L	146 mm
Standard	Manufacturer's standard
Shank Ø D_s	8 mm
Flute length L_c	108 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