

Garant

GARANT Master Steel FEED solid carbide drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 8,6 mm



Order data

Order number	123236 8,6
GTIN	4045197842916
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 : 107.1 mm

Overall length L: 162 mm

Shank Ø D_s : 10 mm

Feed f in steel < 1100 N/mm²: 0.44 mm/rev.

Technical description

Feed f in steel < 1100 N/mm ²	0.44 mm/rev.
Number of cutting edges Z	3
Flute length L _c	120 mm
Shank Ø D _s	10 mm
Nominal Ø D _c	8.6 mm
Standard	Manufacturer's standard
Overall length L	162 mm
Tolerance nominal Ø	h7
recommended maximum drilling depth L ₂	107.1 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