

Garant
GARANT Master Steel SPEED solid carbide drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7: 11,9 mm

Order data

| | |
|--------------|---------------|
| Order number | 122415 11,9 |
| GTIN | 4045197784704 |
| Item class | 11E |

Description
Version:

Developed for use with **very high cutting speeds**. Outstandingly suitable for machines with **low power output** and high speeds.

- **Clear reduction in cutting forces due to special cutter geometry.**
- **Coating for best wear resistance even at high process temperatures.**
- **Polished flutes for good chip clearance.**

A **slim chisel edge** and the **special arrangement of the 4 guide chamfers** ensure **high positioning and alignment accuracy**. Optimised micro-geometry for increased working life and performance capability.

Recommendation:
Maximum drilling depth:

flute length (see table) less 1.5×nominal Ø.

Note:

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

Form HB and HE supplied at the same price as HA.

Form **HB**: order with **No. 122416**.

Form **HE**: order with **No. 122415 + 129100HE**.

Standard: DIN 6537 K

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

Tolerance nominal Ø: h7

recommended maximum drilling depth L_2 : 37.2 mm

Overall length L: 102 mm

Shank Ø D_s : 12 mm

Feed f in steel < 1100 N/mm²: 0.28 mm/rev.

Technical description

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|--|---------------------|
| Shank tolerance | h6 |
| Flute length L_c | 55 mm |
| Shank $\varnothing D_s$ | 12 mm |
| Tolerance nominal \varnothing | h7 |
| Standard | DIN 6537 K |
| Overall length L | 102 mm |
| Nominal $\varnothing D_c$ | 11.9 mm |
| Feed f in steel < 1100 N/mm ² | 0.28 mm/rev. |
| Number of cutting edges Z | 2 |
| recommended maximum drilling depth L_2 | 37.2 mm |
| Series | GARANT Master Steel |
| Coating | TiAlN |
| Tool material | solid carbide |
| Drill depth up to | 4xD |
| Point angle | 135 degrees |
| Shank | DIN 6535 HA to h6 |
| Through-coolant | no |
| Machining strategy | HPC |
| Semi-Standard | yes |
| Colour ring | green |
| Type of product | Jobber drill |

Services

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|------------------------|-----------|
| Shank grinding Type HE | 129100 HE |
|------------------------|-----------|