

Garant
GARANT Master Steel SPEED solid carbide drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7: 6,8 mm

Order data

Order number	122415 6,8
GTIN	4045197784193
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

Semi-Standard: yes

Tolerance nominal Ø: h7

recommended maximum drilling depth L_2 : 23.8 mm

Overall length L: 79 mm

Shank Ø D_s : 8 mm

Feed f in steel < 1100 N/mm²: 0.22 mm/rev.

Technical description

Nominal $\varnothing D_c$	6.8 mm
Flute length L_c	34 mm
Number of cutting edges Z	2
Shank $\varnothing D_s$	8 mm
Overall length L	79 mm
Standard	DIN 6537 K
Tolerance nominal \varnothing	h7
Feed f in steel < 1100 N/mm ²	0.22 mm/rev.
Shank tolerance	h6
recommended maximum drilling depth L_2	23.8 mm
Semi-Standard	yes
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
Colour ring	green
Type of product	Jobber drill

Services

Shank grinding Type HE	129100 HE
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