Hoffmann Group

Garant

GARANT Master Steel SPEED solid carbide drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7: 10,6 mm

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Order data

Order number	122425 10,6
GTIN	4045197785893
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 $L_c = L_2 + 1.5 \times D_c$.
Versions HB and HE supplied at the same price as HA.
Form **HB:** state **No.122426** on the order.
Form **HE:** order with **No.122425 + 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: 39.1 mm
Overall length L: 102 mm
Shank Ø D_s: 12 mm
Feed f in steel < 1100 N/mm^2: 0.28 mm/rev.

Technical description

Shank Ø D_s	12 mm
Shank tolerance	h6
Overall length L	102 mm
Nominal Ø D_c	10.6 mm
Number of cutting edges Z	2
Tolerance nominal Ø	h7
Flute length L_c	55 mm
Standard	DIN 6537 K
Feed f in steel < 1100 N/mm^2	0.28 mm/rev.
recommended maximum drilling depth L_2	39.1 mm
Series	GARANT Master Steel
Coating	TiAlN
Tool material	solid carbide
Drill depth up to	4×D
Point angle	135 degrees
Shank	DIN 6535 HA to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Semi-Standard	yes
Colour ring	green
Type of product	Jobber drill

Services

Shank grinding Type HE	129100 HE