

**Garant**
**GARANT Master Steel SPEED solid carbide drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7: 17,2 mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 122425 17,2   |
| GTIN         | 4045197786340 |
| 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  $L_2$ : 47.2 mm

Overall length L: 123 mm

Shank Ø  $D_s$ : 18 mm

Feed f in steel < 1100 N/mm<sup>2</sup>: 0.35 mm/rev.

## Technical description

|   |                     |
|---|---------------------|
| Feed f in steel < 1100 N/mm <sup>2</sup>          | 0.35 mm/rev.        |
| Overall length L                                  | 123 mm              |
| Shank tolerance                                   | h6                  |
| Flute length L <sub>c</sub>                       | 73 mm               |
| Shank Ø D <sub>s</sub>                            | 18 mm               |
| Tolerance nominal Ø                               | h7                  |
| Standard  | DIN 6537 K          |
| Nominal Ø D <sub>c</sub>                          | 17.2 mm             |
| Number of cutting edges Z                         | 2                   |
| recommended maximum drilling depth L <sub>2</sub> | 47.2 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 |
|------------------------|-----------|