

## Garant

**GARANT Master Steel FEED solid carbide drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7 (mm or inch): 13,5 mm or inch**



### Order data

Order number	122435 13,5
GTIN	4045197787316
Item class	11E

### Description

#### Version:

**3-flute drill**, specially developed for **use at very high feed rates**. Extremely suitable for **machines with high power** output and stable machining conditions.

- **Special point geometry with stable cutting edges and large clearance at the centre permits very high feed rates.**
- **The patented point geometry is optimised for chip flow and generates low cutting forces with good chip breakage.**
- **With 145° point angle for low burr formation when drilling through holes.**

The **sector-leading technology of the chisel point** guarantees **optimum self-centring behaviour** and permits spot drilling on irregular surfaces. 3 guide chamfers guarantee a stable exit from the hole and an exact roundness of the hole.

#### Recommendation:

##### Maximum drilling depth:

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

##### Note:

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

HB and HE shanks are available at the same price as HA.<br>For **HB shanks**: use order **No. 122436**.<br>For **HE shanks**: use order **No. 122435 + 129100HE**.

Standard: DIN 6537 K

Tolerance nominal Ø: h7

Number of cutting edges Z: 3

Tolerance nominal Ø: h7

recommended maximum drilling depth  $L_2$ : 39.8 mm

Overall length L: 107 mm

Shank Ø  $D_s$ : 14 mm

Feed f in steel < 1100 N/mm<sup>2</sup>: 0.56 mm/rev.

## Technical description

Flute length $L_c$	60 mm
Nominal $\varnothing D_c$	13.5 mm
Shank $\varnothing D_s$	14 mm
Standard	DIN 6537 K
Feed $f$ in steel $< 1100 \text{ N/mm}^2$	0.56 mm/rev.
Tolerance nominal $\varnothing$	h7
Number of cutting edges $Z$	3
Overall length $L$	107 mm
recommended maximum drilling depth $L_2$	39.8 mm
Series	GARANT Master Steel
Coating	TiAlN
Tool material	solid carbide
Drill depth up to	4xD
Point angle	145 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
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