ii Hoffmann Group

Garant

GARANT Master Steel FEED solid carbide drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7 (mm or inch): 16,5 mm or inch

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Order data

Order number	122435 16,5
GTIN	4045197787439
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.
For **HB shanks:** use order **No. 122436**.
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: 48.3 mm
Overall length L: 123 mm
Shank Ø D_s: 18 mm
Feed f in steel < 1100 N/mm^2: 0.66 mm/rev.

Technical description

Shank $\varnothing$ D_s	18 mm
Nominal $\varnothing$ D_c	16.5 mm
Feed f in steel < 1100 N/mm^2	0.66 mm/rev.
Flute length L_c	73 mm
Tolerance nominal $\varnothing$	h7
Standard	DIN 6537 K
Number of cutting edges Z	3
Overall length L	123 mm
recommended maximum drilling depth L_2	48.3 mm
Series	GARANT Master Steel
Coating	TiAlN
Tool material	solid carbide
Drill depth up to	4×D
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