

Garant

GARANT Master Steel FEED solid carbide drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7 (mm or inch): 18,2 mm or inch



Order data

Order number	122435 18,2
GTIN	4045197787507
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 : 51.7 mm

Overall length L: 131 mm

Shank Ø D_s : 20 mm

Feed f in steel < 1100 N/mm²: 0.69 mm/rev.

Technical description

Tolerance nominal \varnothing	h7
Flute length L_c	79 mm
Number of cutting edges Z	3
Shank $\varnothing D_s$	20 mm
Nominal $\varnothing D_c$	18.2 mm
Standard	DIN 6537 K
Overall length L	131 mm
Feed f in steel < 1100 N/mm ²	0.69 mm/rev.
recommended maximum drilling depth L_2	51.7 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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