Hoffmann Group

Garant

GARANT Master Steel SPEED solid carbide drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7: 15,5 mm

Order data

Order number	122715 15,5
GTIN	4045197788719
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 $L_c = L_2 + 1.5 \times D_c$.
Form HB and HE supplied at the same price as HA.
Form **HB:** order with **No. 122716**.
Form **HE:** order with **No. 122715 + 129100HE**.
Standard: DIN 6537
Tolerance nominal Ø: h7
Number of cutting edges Z: 2
Tolerance nominal Ø: h7
recommended maximum drilling depth L_2: 59.8 mm
Overall length L: 133 mm
Shank Ø D_s: 16 mm
Feed f in steel < 1100 N/mm^2: 0.34 mm/rev.

Technical description

Flute length L_c	83 mm
Number of cutting edges Z	2
Overall length L	133 mm
Standard	DIN 6537
Shank Ø D_s	16 mm
Tolerance nominal Ø	h7
Nominal Ø D_c	15.5 mm
Feed f in steel < 1100 N/mm^2	0.34 mm/rev.
recommended maximum drilling depth L_2	59.8 mm
Series	GARANT Master Steel
Coating	TiAlN
Tool material	solid carbide
Drill depth up to	6×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