

# GARANT Master Steel SPEED solid carbide drill, plain shank DIN 6535 HA, TiAIN, Ø DC h7: 9,55 mm



#### **Order data**

Order number	122715 9,55
GTIN	4045197821416
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  $1.5 \times \text{nominal } \emptyset$ .

#### 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<sub>2</sub>: 46.7 mm

Overall length L: 103 mm Shank Ø D<sub>s</sub>: 10 mm

Feed f in steel < 1100 N/mm<sup>2</sup>: 0.26 mm/rev.

### **Technical description**

StandardDIN 6537Nominal $\varnothing$ $D_c$ 9.55 mmTolerance nominal $\varnothing$ h7Feed f in steel < 1100 N/mm²0.26 mm/rev.Overall length L103 mmShank $\varnothing$ $D_s$ 10 mmNumber of cutting edges Z2recommended maximum drilling depth $L_2$ 46.7 mmSeriesGARANT Master SteelCoatingTiAINTool materialsolid carbideDrill depth up to $6 \times D$ Point angle135 degreesShankDIN 6535 HA to h6	Flute length L <sub>c</sub>	61 mm
Nominal Ø D <sub>c</sub> Tolerance nominal Ø  Feed f in steel < 1100 N/mm²  Overall length L  Shank Ø D <sub>s</sub> 10 mm  Number of cutting edges Z  recommended maximum drilling depth L₂  Feries  GARANT Master Steel  Coating  TiAlN  Tool material  Solid carbide  Drill depth up to  Point angle  Shank  DIN 6535 HA to h6  Through-coolant  Machining strategy  HPC  Semi-Standard  Colour ring  102 mm/rev.  103 mm  104 mm  105 mm  107 mm  108 mm  109 mm  1		
Tolerance nominal Ø Feed f in steel < 1100 N/mm² Overall length L 103 mm Shank Ø D₃ 110 mm Number of cutting edges Z recommended maximum drilling depth L₂ Series GARANT Master Steel Coating TiAIN Tool material Solid carbide Drill depth up to Point angle Shank DIN 6535 HA to h6 Through-coolant Machining strategy HPC Semi-Standard Colour ring Nammerev. 103 mm 103 mm 104 mm 105 mm 105 mm 105 mm 107 mm 108 mm 109 mm	Standard	DIN 6537
Feed f in steel < 1100 N/mm²  Overall length L  Shank Ø D₃  10 mm  Number of cutting edges Z  recommended maximum drilling depth L₂  Feries  GARANT Master Steel  Coating  TiAlN  Tool material  Solid carbide  Drill depth up to  Point angle  Shank  DIN 6535 HA to h6  Through-coolant  Machining strategy  HPC  Semi-Standard  Colour ring  103 mm  104 mm  105 mm  6A7 mm  6A8 mild carbide  135 degrees  6A8 mild pieces  6A8 mild	Nominal Ø D <sub>c</sub>	9.55 mm
Overall length L $103  \text{mm}$ Shank $\emptyset$ Ds $10  \text{mm}$ Number of cutting edges Z2recommended maximum drilling depth L2 $46.7  \text{mm}$ SeriesGARANT Master SteelCoatingTiAINTool materialsolid carbideDrill depth up to $6 \times D$ Point angle $135  \text{degrees}$ ShankDIN 6535 HA to h6Through-coolantyes, with 25 barMachining strategyHPCSemi-StandardyesColour ringgreen	Tolerance nominal Ø	h7
Shank Ø D₃       10 mm         Number of cutting edges Z       2         recommended maximum drilling depth L₂       46.7 mm         Series       GARANT Master Steel         Coating       TiAIN         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	Feed f in steel < 1100 N/mm <sup>2</sup>	0.26 mm/rev.
Number of cutting edges Z recommended maximum drilling depth L₂ Reries GARANT Master Steel Goating TiAIN Tool material Solid carbide Drill depth up to Point angle Shank DIN 6535 HA to h6 Through-coolant Machining strategy HPC Semi-Standard Ves Golour ring  2 46.7 mm SARANT Master Steel CARANT Master Steel TiAIN Tool material Solid carbide A×D Final Solid carbide A×D Final Solid carbide Final Solid carb	Overall length L	103 mm
recommended maximum drilling depth L2  46.7 mm  Series  GARANT Master Steel  TiAIN  Tool material  Drill depth up to  Point angle  Shank  DIN 6535 HA to h6  Through-coolant  Machining strategy  HPC  Semi-Standard  Colour ring  GARANT Master Steel  A6.7 mm  46.7 mm  46.7 mm  A6.7 mm	Shank Ø D <sub>s</sub>	10 mm
Series GARANT Master Steel Coating TiAIN 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	Number of cutting edges Z	2
Coating TiAIN  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	recommended maximum drilling depth L <sub>2</sub>	46.7 mm
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	Series	GARANT Master Steel
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	Coating	TiAlN
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	Tool material	solid carbide
Shank  DIN 6535 HA to h6  Through-coolant  Machining strategy  HPC  Semi-Standard  yes  Colour ring  green	Drill depth up to	6×D
Through-coolant yes, with 25 bar  Machining strategy HPC  Semi-Standard yes  Colour ring green	Point angle	135 degrees
Machining strategy HPC Semi-Standard yes Colour ring green	Shank	DIN 6535 HA to h6
Semi-Standard yes Colour ring green	Through-coolant	yes, with 25 bar
Colour ring green	Machining strategy	HPC
-	Semi-Standard	yes
Type of product Jobber drill	Colour ring	green
	Type of product	Jobber drill

## Services

Shank grinding Type HE 129100 HE