

## Garant

**GARANT Master Steel FEED solid carbide drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7: 8,5 mm or inch**



### Order data

Order number	122725 8,5
GTIN	4045197789341
Item class	11E

### Description

#### Version:

**3-flute drill**, specially developed for use at **very high feed rates**. Outstandingly suitable for **machines with high installed power** and stable operating conditions.

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

The **sector-leading technology of the chisel edge** 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  $L_c = L_2 + 1.5 \times D_c$ .

Form HB and HE supplied at the same price as HA.

Form **HB**: order with **No. 122726**.

Form **HE**: order with **No. 122725 + 129100HE**.

Machining strategy: HPC

Standard: DIN 6537

Tolerance nominal Ø: h7

Number of cutting edges Z: 3

Semi-Standard: yes

Tolerance nominal Ø: h7

recommended maximum drilling depth  $L_2$ : 48.3 mm

Overall length L: 103 mm

Shank  $\varnothing D_s$ : 10 mm

Feed  $f$  in steel < 1100 N/mm<sup>2</sup>: 0.44 mm/rev.

## Technical description

Nominal $\varnothing D_c$	8.5 mm
Shank $\varnothing D_s$	10 mm
Flute length $L_c$	61 mm
Standard	DIN 6537
Number of cutting edges $Z$	3
Tolerance nominal $\varnothing$	h7
Feed $f$ in steel < 1100 N/mm <sup>2</sup>	0.44 mm/rev.
Overall length $L$	103 mm
recommended maximum drilling depth $L_2$	48.3 mm
Semi-Standard	yes
Series	GARANT Master Steel
Coating	TiAlN
Tool material	solid carbide
Drill depth up to	6×D
Point angle	145 degrees
Shank	DIN 6535 HA to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Colour ring	green
Type of product	Jobber drill

## Services

Shank grinding Type HE	129100 HE
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