

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



Order data

Order number	122725 8
GTIN	4045197789297
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 $1.5 \times \text{nominal } \emptyset$.

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. 122726.

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

Standard: DIN 6537

Tolerance nominal Ø: h7

Number of cutting edges Z: 3

Tolerance nominal Ø: h7

recommended maximum drilling depth L₂: 41 mm

Overall length L: 91 mm

Shank Ø D_s: 8 mm

Feed f in steel < 1100 N/mm²: 0.37 mm/rev.

Technical description

Shank Ø D₅ 8 mm Flute length L₅ 53 mm Feed f in steel < 1100 N/mm² 0.37 mm/rev. Number of cutting edges Z 3 Overall length L 91 mm Tolerance nominal Ø h7 recommended maximum drilling depth L₂ 41 mm 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 Semi-Standard yes Colour ring green	Nominal Ø D _c	8 mm
Flute length L _c Feed f in steel < 1100 N/mm² Number of cutting edges Z Overall length L Tolerance nominal Ø recommended maximum drilling depth L ₂ Series GARANT Master Steel Coating TiAIN Tool material Drill depth up to Point angle Shank DIN 6535 HA to h6 Through-coolant Machining strategy HPC Semi-Standard Colour ring Touth manual Standard Solid carbide TiAIN Tool material Solid carbide Drill depth up to Figure 145 degrees Shank DIN 6535 HA to h6 Through-coolant Machining strategy HPC Semi-Standard yes Colour ring Garant TiAIN Tool material Solid carbide TiAIN Tool material Solid carbide TiAIN Tool material Solid carbide The Machining strategy HPC Semi-Standard yes Colour ring	Standard	DIN 6537
Feed f in steel < 1100 N/mm² Number of cutting edges Z Overall length L Foliance nominal Ø Frecommended maximum drilling depth L₂ Foreiss For	Shank Ø D _s	8 mm
Number of cutting edges Z Overall length L 191 mm Tolerance nominal Ø 177 recommended maximum drilling depth L₂ 41 mm Series GARANT Master Steel Coating TiAIN 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 Semi-Standard yes Colour ring green	Flute length L _c	53 mm
Overall length L Tolerance nominal Ø h7 recommended maximum drilling depth L₂ Coating TiAlN Tool material Drill depth up to Point angle Shank DIN 6535 HA to h6 Through-coolant Machining strategy Semi-Standard Colour ring 91 mm h7 h7 A1 mm SARANT Master Steel TiAlN Solid carbide 6×D 145 degrees DIN 6535 HA to h6 HPC Semi-Standard yes Colour ring green	Feed f in steel < 1100 N/mm ²	0.37 mm/rev.
Tolerance nominal Ø h7 recommended maximum drilling depth L₂ 41 mm Series GARANT Master Steel Coating TiAIN 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 Semi-Standard yes Colour ring green	Number of cutting edges Z	3
recommended maximum drilling depth L ₂ 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 All mm GARANT Master Steel TiAIN Solid carbide 6×D 145 degrees DIN 6535 HA to h6 Yes, with 25 bar HPC yes	Overall length L	91 mm
Series GARANT Master Steel Coating TiAIN 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 Semi-Standard yes Colour ring green	Tolerance nominal Ø	h7
Coating TiAIN 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 Semi-Standard yes Colour ring green	recommended maximum drilling depth L ₂	41 mm
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 Semi-Standard yes Colour ring green	Series	GARANT Master Steel
Drill depth up to Point angle Shank DIN 6535 HA to h6 Through-coolant Machining strategy Semi-Standard Colour ring M×D 145 degrees DIN 6535 HA to h6 yes, with 25 bar HPC yes green	Coating	TiAIN
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	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	145 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
	Colour ring	green
Type of product Jobber drill	Type of product	Jobber drill

Services

Shank grinding Type HE	129100 HE
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