

GARANT Master Steel FEED solid carbide drill, plain shank DIN 6535 HA, TiAIN, Ø DC h7 (mm or inch): 9,7 mm or inch



Order data

Order number	122725 9,7
GTIN	4045197789464
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: 46.5 mm

Overall length L: 103 mm

Shank Ø D_s: 10 mm

Feed f in steel $< 1100 \text{ N/mm}^2$: 0.44 mm/rev.

Technical description

Overall length L 103mm Shank \varnothing D $_s$ 10mm Feed f in steel < 1100N/mm^2 0.44mm/rev .Number of cutting edges Z 3 StandardDIN 6537Tolerance nominal \varnothing h7recommended maximum drilling depth L $_2$ 46.5mm SeriesGARANT Master SteelCoatingTiAINTool materialsolid carbideDrill depth up to $6 \times D$ Point angle 145degrees ShankDIN 6535 HA to h6	Flores London I	C1
Overall length L Shank Ø D _s 10 mm Feed f in steel < 1100 N/mm² Number of cutting edges Z Standard DIN 6537 Tolerance nominal Ø 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 103 mm 103 mm 104 mm 105 mm 104 mm/rev. A 44 mm/rev. A 44 mm/rev. A 46.5 mm Saries GARANT Master Steel Coating TiAIN Tool material Solid carbide Drill depth up to A 50 mm A 50 mm A 50 mm A 50 mm A 6 mm A 70 mm A 7	Flute length L _c	61 mm
Shank Ø D₃ 10 mm Feed f in steel < 1100 N/mm²	Nominal Ø D _c	9.7 mm
Feed f in steel < 1100 N/mm² Number of cutting edges Z Standard DIN 6537 Tolerance nominal Ø recommended maximum drilling depth L₂ Series 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 Code to the marker of th	Overall length L	103 mm
Number of cutting edges Z Standard DIN 6537 Tolerance nominal Ø recommended maximum drilling depth L₂ A6.5 mm 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 yes Colour ring GIN 6537 A6.5 mm SARANT Master Steel A6.5 mm SARANT Master Steel TiAIN Solid carbide AFA D Point angle 145 degrees HPC Semi-Standard yes Colour ring Green	Shank Ø D₅	10 mm
Standard DIN 6537 Tolerance nominal Ø h7 recommended maximum drilling depth L₂ 46.5 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	Feed f in steel < 1100 N/mm ²	0.44 mm/rev.
Tolerance nominal Ø h7 recommended maximum drilling depth L₂ 46.5 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 L2 46.5 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	Standard	DIN 6537
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	46.5 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 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	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 yes, with 25 bar 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
Type of product Jobber drill	Colour ring	green
	Type of product	Jobber drill

Services

Shank grinding Type HE 129100 HE	Shank grinding Type HE	129100 HE
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