

## Garant

### GARANT Master Steel SPEED solid carbide drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7: 16,8 mm



## Order data

|              |               |
|--------------|---------------|
| Order number | 123025 16,8   |
| GTIN         | 4045197844668 |
| Item class   | 11E           |

## Description

### Version:

Developed for use with **very high cutting speeds**. Outstandingly suitable for machines with **low installed power** 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 point** 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  $L_c = L_2 + 1.5 \times D_c$ .

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

Form **HB**: order with **No. 123026**.

Form **HE**: order with **No. 123025 + 129100HE**.

Standard: Manufacturer's standard

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

Tolerance nominal Ø: h7

recommended maximum drilling depth  $L_2$ : 145.8 mm

Overall length L: 222 mm

Shank Ø  $D_s$ : 18 mm

Feed f in steel < 1100 N/mm<sup>2</sup>: 0.29 mm/rev.

## Technical description

|  |                         |
|--|-------------------------|
| Nominal $\varnothing D_c$                | 16.8 mm                 |
| Overall length L                         | 222 mm                  |
| recommended maximum drilling depth $L_2$ | 145.8 mm                |
| Standard                                 | Manufacturer's standard |
| Number of cutting edges Z                | 2                       |
| Tolerance nominal $\varnothing$          | h7                      |
| Flute length $L_c$                       | 171 mm                  |
| Shank $\varnothing D_s$                  | 18 mm                   |
| Feed f in steel < 1100 N/mm <sup>2</sup> | 0.29 mm/rev.            |
| Series                                   | GARANT Master Steel     |
| Coating                                  | TiAlN                   |
| Tool material                            | Solid carbide           |
| Drill depth up to                        | 8×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 |
|------------------------|-----------|