## Garant

# GARANT Master Steel SPEED solid carbide drill, plain shank DIN 6535 HA, TIAIN, Ø DC h7: 7,9 mm

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## Order data

Order number	123025 7,9
GTIN	4045197844064
Item class	11E

### Description

#### Version:

Developed for use with **very high cutting speeds**. Outstandingly suitable for machines with **low installed power** and high speeds.

- $\cdot\,$  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  $1.5 \times nominal \emptyset$ .

#### 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<sub>2</sub>: 64.2 mm

Overall length L: 114 mm

Shank Ø D<sub>s</sub>: 8 mm

Feed f in steel < 1100 N/mm<sup>2</sup>: 0.15 mm/rev.

## **Technical description**

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Feed f in steel < 1100 N/mm²	recommended maximum drilling depth $L_2$	64.2 mm
Shank Ø D,8 mmNumber of cutting edges Z2Overall length L114 mmFlute length L_c76 mmNominal Ø D_c7.9 mmTolerance nominal Øh7SeriesGARANT Master SteelCoatingTiAlNTool materialSolid carbideDrill depth up to8×DPoint angle1135 degreesShankDIN 6535 HA to h6	Feed f in steel < 1100 N/mm <sup>2</sup>	0.15 mm/rev.
Number of cutting edges Z2Overall length L114 mmFlute length Lc76 mmNominal Ø Dc7.9 mmTolerance nominal Øh7SeriesGARANT Master SteelCoatingTiAINTool materialSolid carbideDrill depth up to8×DPoint angle135 degreesShankDIN 6535 HA to h6	Standard	Manufacturer's standard
Overall length L114 mmFlute length Lc76 mmNominal Ø Dc7.9 mmTolerance nominal Øh7SeriesGARANT Master SteelCoatingTiAINTool materialSolid carbideDrill depth up to8×DPoint angle135 degreesShankDIN 6535 HA to h6	Shank Ø Ds	8 mm
Flute length L76 mmNominal Ø Dc7.9 mmTolerance nominal Øh7SeriesGARANT Master SteelCoatingTiAlNTool materialSolid carbideDrill depth up to8×DPoint angle135 degreesShankDIN 6535 HA to h6	Number of cutting edges Z	2
Nominal Ø Dc7.9 mmTolerance nominal Øh7SeriesGARANT Master SteelCoatingTiAlNTool materialSolid carbideDrill depth up to8×DPoint angle135 degreesShankDIN 6535 HA to h6	Overall length L	114 mm
Tolerance nominal Øh7SeriesGARANT Master SteelCoatingTiAlNTool materialSolid carbideDrill depth up to8×DPoint angle135 degreesShankDIN 6535 HA to h6	Flute length L <sub>c</sub>	76 mm
SeriesGARANT Master SteelCoatingTiAINTool materialSolid carbideDrill depth up to $8 \times D$ Point angle135 degreesShankDIN 6535 HA to h6	Nominal Ø D <sub>c</sub>	7.9 mm
CoatingTiAlNTool materialSolid carbideDrill depth up to8×DPoint angle135 degreesShankDIN 6535 HA to h6	Tolerance nominal Ø	h7
Tool materialSolid carbideDrill depth up to8×DPoint angle135 degreesShankDIN 6535 HA to h6	Series	GARANT Master Steel
Drill depth up to8×DPoint angle135 degreesShankDIN 6535 HA to h6	Coating	TiAIN
Point angle135 degreesShankDIN 6535 HA to h6	Tool material	Solid carbide
Shank DIN 6535 HA to h6	Drill depth up to	8×D
	Point angle	135 degrees
Through coolant	Shank	DIN 6535 HA to h6
Through-coolant yes, with 25 bar	Through-coolant	yes, with 25 bar
Machining strategy HPC	Machining strategy	HPC
Semi-Standard yes	Semi-Standard	yes
Colour ring green	Colour ring	green
Type of product Jobber drill	Type of product	Jobber drill

## Services

Shank grinding Type HE	129100 HE
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