

GARANT Master Steel SPEED solid carbide drill, Weldon shank DIN 6535 HB, TiAIN, Ø DC h7: 13,5 mm



Order data

Order number	123026 13,5
GTIN	4045197846976
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:

clamping slot length (see table) less $1.5 \times \text{nominal } \emptyset$.

Note:

Flute length $L_c = L_2 + 1.5 \times D_c$.

Standard: Manufacturer's standard

Tolerance nominal Ø: h7 Number of cutting edges Z: 2 Tolerance nominal Ø: h7

recommended maximum drilling depth L₂: 112.8 mm

Overall length L: 178 mm Shank Ø D_s: 14 mm

Feed f in steel < 1100 N/mm²: 0.23 mm/rev.

Technical description

recommended maximum drilling depth L_2 112.8 mm

Number of cutting edges Z Flute length L, Overall length L 178 mm Nominal Ø Dc 13.5 mm Standard Manufacturer's standard Shank Ø Ds, 14 mm Tolerance nominal Ø Series GARANT Master Steel Coating TiAlN Tool material Solid carbide Drill depth up to 8×D Point angle 135 degrees Cutting direction Shank DIN 6535 HB to h6 Through-coolant Meaning strategy HPC Semi-Standard Ves Colour ring Type of product Jobber drill	Food finate al. (1100 N/mm²	0.23 mm/rev.
Flute length L _c Overall length L Nominal Ø D _c 13.5 mm Standard Manufacturer's standard Shank Ø D _s 14 mm Tolerance nominal Ø h7 Series GARANT Master Steel Coating TiAlN Tool material Solid carbide Drill depth up to 8×D Point angle Cutting direction Shank DIN 6535 HB to h6 Through-coolant Machining strategy HPC Semi-Standard Colour ring T183 mm 133 mm 133 mm 14 mm 158 mm Manufacturer's standard Manufacturer's standard Shank DIN 6535 HB to h6 Through-coolant yes, to 25 bar Machining strategy HPC Semi-Standard yes Colour ring Green	Feed f in steel < 1100 N/mm ²	0.23 Hilli/Tev.
Overall length L 178mm Nominal \oslash D_c 13.5mm StandardManufacturer's standardShank \oslash D_s 14mm Tolerance nominal \oslash $h7$ SeriesGARANT Master SteelCoatingTiAINTool materialSolid carbideDrill depth up to $8 \times D$ Point angle 135degrees Cutting directionright-handShankDIN 6535 HB to h6Through-coolantyes, to 25 barMachining strategyHPCSemi-StandardyesColour ringgreen	Number of cutting edges Z	2
Nominal Ø Dc 13.5 mm Standard Manufacturer's standard Shank Ø Ds 14 mm Tolerance nominal Ø h7 Series GARANT Master Steel Coating TiAIN Tool material Solid carbide Drill depth up to 8×D Point angle 135 degrees Cutting direction right-hand Shank DIN 6535 HB to h6 Through-coolant yes, to 25 bar Machining strategy HPC Semi-Standard yes Colour ring green	Flute length L _c	133 mm
Standard Manufacturer's standard Shank Ø D₂ 14 mm Tolerance nominal Ø h7 Series GARANT Master Steel Coating TiAIN Tool material Solid carbide Drill depth up to 8×D Point angle 135 degrees Cutting direction right-hand Shank DIN 6535 HB to h6 Through-coolant yes, to 25 bar Machining strategy HPC Semi-Standard yes Colour ring green	Overall length L	178 mm
Shank Ø D₅14 mmTolerance nominal Øh7SeriesGARANT Master SteelCoatingTiAINTool materialSolid carbideDrill depth up to8×DPoint angle135 degreesCutting directionright-handShankDIN 6535 HB to h6Through-coolantyes, to 25 barMachining strategyHPCSemi-StandardyesColour ringgreen	Nominal Ø D _c	13.5 mm
Tolerance nominal Ø Series GARANT Master Steel Coating TiAIN Tool material Solid carbide Drill depth up to 8×D Point angle 135 degrees Cutting direction right-hand Shank DIN 6535 HB to h6 Through-coolant yes, to 25 bar Machining strategy HPC Semi-Standard yes Colour ring GARANT Master Steel And	Standard	Manufacturer's standard
Series GARANT Master Steel Coating TiAIN Tool material Solid carbide Drill depth up to 8×D Point angle 135 degrees Cutting direction right-hand Shank DIN 6535 HB to h6 Through-coolant yes, to 25 bar Machining strategy HPC Semi-Standard yes Colour ring green	Shank Ø D _s	14 mm
Coating TiAIN Tool material Solid carbide Drill depth up to 8×D Point angle 135 degrees Cutting direction right-hand Shank DIN 6535 HB to h6 Through-coolant yes, to 25 bar Machining strategy HPC Semi-Standard yes Colour ring green	Tolerance nominal Ø	h7
Tool material Drill depth up to 8×D Point angle 135 degrees Cutting direction right-hand Shank DIN 6535 HB to h6 Through-coolant Machining strategy HPC Semi-Standard yes Colour ring green	Series	GARANT Master Steel
Drill depth up to 8×D Point angle 135 degrees Cutting direction right-hand Shank DIN 6535 HB to h6 Through-coolant yes, to 25 bar Machining strategy HPC Semi-Standard yes Colour ring green	Coating	TiAlN
Point angle 135 degrees Cutting direction right-hand Shank DIN 6535 HB to h6 Through-coolant yes, to 25 bar Machining strategy HPC Semi-Standard yes Colour ring green	Tool material	Solid carbide
Cutting direction right-hand Shank DIN 6535 HB to h6 Through-coolant yes, to 25 bar Machining strategy HPC Semi-Standard yes Colour ring green	Drill depth up to	8×D
Shank DIN 6535 HB to h6 Through-coolant yes, to 25 bar Machining strategy HPC Semi-Standard yes Colour ring green	Point angle	135 degrees
Through-coolant yes, to 25 bar Machining strategy HPC Semi-Standard yes Colour ring green	Cutting direction	right-hand
Machining strategy HPC Semi-Standard yes Colour ring green	Shank	DIN 6535 HB to h6
Semi-Standard yes Colour ring green	Through-coolant	yes, to 25 bar
Colour ring green	Machining strategy	HPC
	Semi-Standard	yes
Type of product Jobber drill	Colour ring	green
	Type of product	Jobber drill