Garant

GARANT Master Steel FEED solid carbide drill, plain shank DIN 6535 HA, TiAlN, ⌀ DC h7 (mm or inch): 12,2 mm or inch

Order data

Order number	123035 12,2
GTIN	4045197839909
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.**

The **sector-leading technology of the drill point** guarantees **optimum self-centring behaviour.** 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×nominal ⌀.
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. 123036**.
Form **HE:** order with **No. 123035 + 129100HE**.
Standard: Manufacturer's standard
Tolerance nominal ⌀: h7
Number of cutting edges Z: 3
Tolerance nominal ⌀: h7
recommended maximum drilling depth L_2: 114.7 mm
Overall length L: 178 mm
Shank ⌀ D_s: 14 mm
Feed f in steel < 1100 N/mm^2: 0.56 mm/rev.

Technical description

Feed f in steel < 1100 N/mm^2	0.56 mm/rev.
Shank ⌀ D_s	14 mm
recommended maximum drilling depth L_2	114.7 mm
Flute length L_c	133 mm
Overall length L	178 mm
Standard	Manufacturer's standard
Tolerance nominal ⌀	h7
Nominal ⌀ D_C	12.2 mm
Number of cutting edges Z	3
Series	GARANT Master Steel
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	8×D
Point angle	140 degrees
Shank	DIN 6535 HA to h6
Through-coolant	yes, to 25 bar
Machining strategy	HPC
Semi-Standard	yes
Colour ring	green
Type of product	Jobber drill

Services

Shank grinding Type HE	129100 HE