

## Garant

**GARANT Master Steel FEED solid carbide drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7 (mm or inch): 18,2 mm or inch**



### Order data

Order number	123035 18,2
GTIN	4045197840141
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  $1.5 \times \text{nominal } \varnothing$ .

##### 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  $\varnothing$ : h7

Number of cutting edges Z: 3

Tolerance nominal  $\varnothing$ : h7

recommended maximum drilling depth  $L_2$ : 162.7 mm

Overall length L: 243 mm

Shank  $\varnothing D_s$ : 20 mm

Feed f in steel  $< 1100 \text{ N/mm}^2$ : 0.69 mm/rev.

## Technical description

Number of cutting edges Z	3
Nominal $\varnothing D_c$	18.2 mm
Feed f in steel < 1100 N/mm <sup>2</sup>	0.69 mm/rev.
Tolerance nominal $\varnothing$	h7
Flute length $L_c$	190 mm
Overall length L	243 mm
recommended maximum drilling depth $L_2$	162.7 mm
Shank $\varnothing D_s$	20 mm
Standard	Manufacturer's standard
Series	GARANT Master Steel
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	8xD
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
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