

**Garant**

**GARANT Master Steel FEED solid carbide drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7 (mm or inch): 6,9 mm or inch**


**Order data**

Order number	123035 6,9
GTIN	4045197839381
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 Ø.

**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 Ø: h7

Number of cutting edges Z: 3

Tolerance nominal Ø: h7

recommended maximum drilling depth  $L_2$ : 65.7 mm

Overall length L: 114 mm

Shank Ø  $D_s$ : 8 mm

Feed  $f$  in steel < 1100 N/mm<sup>2</sup>: 0.37 mm/rev.

## Technical description

Tolerance nominal Ø	h7
recommended maximum drilling depth L <sub>2</sub>	65.7 mm
Number of cutting edges Z	3
Overall length L	114 mm
Standard	Manufacturer's standard
Flute length L <sub>c</sub>	76 mm
Nominal Ø D <sub>c</sub>	6.9 mm
Feed f in steel < 1100 N/mm <sup>2</sup>	0.37 mm/rev.
Shank Ø D <sub>s</sub>	8 mm
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
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