Garant

GARANT Master Steel FEED solid carbide drill, plain shank DIN 6535 HA, TIAIN, Ø DC h7 (mm or inch): 7,4 mm or inch

and the state of the state

Order data

Order number	123035 7,4
GTIN	4045197839435
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 L₂: 64.9 mm

Overall length L: 114 mm

Shank Ø D₅: 8 mm

Feed f in steel < 1100 N/mm²: 0.37 mm/rev.

Technical description

Feed f in steel < 1100 N/mm²	Tolerance nominal Ø	h7
Overall length L114 mmStandardManufacturer's standardrecommended maximum drilling depth L264.9 mmNominal Ø Dc7.4 mmShank Ø D38 mmFlute length Lc8 mmSeriesGARANT Master SteelCoatingTiAINTool materialSolid carbideDrill depth up to8 xDPoint angle140 degreesShankDIN 6535 HA to h6Through-coolantyes, to 25 barMachining strategyHPCSemi-Standardyes	Number of cutting edges Z	3
StandardManufacturer's standardrecommended maximum drilling depth L264.9 mmNominal Ø Dc7.4 mmShank Ø Ds8 mmFlute length Lc76 mmSeriesGARANT Master SteelCoatingTIAINTool materialSolid carbideDrill depth up to8×DPoint angle140 degreesShankDIN 6535 HA to h6Through-coolantyes, to 25 barMachining strategyHPCSemi-Standardyes	Feed f in steel < 1100 N/mm ²	0.37 mm/rev.
recommended maximum drilling depth L₂64.9 mmNominal Ø Dc7.4 mmShank Ø Ds8 mmFlute length Lc76 mmSeriesGARANT Master SteelCoatingTiAINTool materialSolid carbideDrill depth up to8×DPoint angle140 degreesShankDIN 6535 HA to h6Through-coolantYes, to 25 barMachining strategyHPCSemi-Standardyes	Overall length L	114 mm
Nominal Ø Dc7.4 mmShank Ø D,8 mmFlute length Lc76 mmSeriesGARANT Master SteelCoatingTiAINTool materialSolid carbideDrill depth up to8 × DPoint angle140 degreesShankDIN 6535 HA to h6Through-coolantyes, to 25 barMachining strategyHPCSemi-Standardyes	Standard	Manufacturer's standard
Shank Ø D,8 mmFlute length L,76 mmSeriesGARANT Master SteelCoatingTiAINTool materialSolid carbideDrill depth up to8×DPoint angle140 degreesShankDIN 6535 HA to h6Through-coolantYes, to 25 barMachining strategyHPCSemi-Standardyes	recommended maximum drilling depth L_2	64.9 mm
Flute length L Coating76 mmSeriesGARANT Master SteelCoatingTiAINTool materialSolid carbideDrill depth up to8×DPoint angle140 degreesShankDIN 6535 HA to h6Through-coolantyes, to 25 barMachining strategyHPCSemi-Standardyes	Nominal Ø D _c	7.4 mm
SeriesGARANT Master SteelCoatingTiAINTool materialSolid carbideDrill depth up to8×DPoint angle140 degreesShankDIN 6535 HA to h6Through-coolantYes, to 25 barMachining strategyHPCSemi-Standardyes	Shank Ø D _s	8 mm
CoatingTiAlNTool materialSolid carbideDrill depth up to $8 \times D$ Point angle140 degreesShankDIN 6535 HA to h6Through-coolantyes, to 25 barMachining strategyHPCSemi-Standardyes	Flute length L _c	76 mm
Tool materialSolid carbideDrill depth up to8×DPoint angle140 degreesShankDIN 6535 HA to h6Through-coolantyes, to 25 barMachining strategyHPCSemi-Standardyes	Series	GARANT Master Steel
Drill depth up to8×DPoint angle140 degreesShankDIN 6535 HA to h6Through-coolantyes, to 25 barMachining strategyHPCSemi-Standardyes	Coating	TiAIN
Point angle140 degreesShankDIN 6535 HA to h6Through-coolantyes, to 25 barMachining strategyHPCSemi-Standardyes	Tool material	Solid carbide
ShankDIN 6535 HA to h6Through-coolantyes, to 25 barMachining strategyHPCSemi-Standardyes	Drill depth up to	8×D
Through-coolantyes, to 25 barMachining strategyHPCSemi-Standardyes	Point angle	140 degrees
Machining strategyHPCSemi-Standardyes	Shank	DIN 6535 HA to h6
Semi-Standard yes	Through-coolant	yes, to 25 bar
	Machining strategy	HPC
Colour ring green	Semi-Standard	yes
	Colour ring	green
Type of product Jobber drill	Type of product	Jobber drill

Services

Shank grinding Type HE	129100 HE
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