

Garant

GARANT Master Steel FEED solid carbide drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7 (mm or inch): 8,6 mm or inch



Order data

Order number	123035 8,6
GTIN	4045197839558
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 : 82.1 mm

Overall length L: 142 mm

Shank $\varnothing D_s$: 10 mm

Feed f in steel $< 1100 \text{ N/mm}^2$: 0.44 mm/rev.

Technical description

Shank $\varnothing D_s$	10 mm
Number of cutting edges Z	3
Flute length L_c	95 mm
Overall length L	142 mm
Feed f in steel < 1100 N/mm ²	0.44 mm/rev.
Nominal $\varnothing D_c$	8.6 mm
Standard	Manufacturer's standard
Tolerance nominal \varnothing	h7
recommended maximum drilling depth L_2	82.1 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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