

## Garant

### GARANT Master Steel SPEED solid carbide drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7: 12,2 mm



#### Order data

|              |               |
|--------------|---------------|
| Order number | 123225 12,2   |
| GTIN         | 4045197845702 |
| Item class   | 11E           |

#### Description

##### Version:

Developed for use with **very high cutting speeds**. Outstandingly suitable for machines with **low installed power** and high speeds.

- **Clear reduction in cutting forces due to special cutter geometry.**
- **Coating for best wear resistance even at high process temperatures.**
- **Polished flutes for good chip clearance.**

A **slim chisel point** and the **special arrangement of the 4 guide chamfers** ensure **high positioning and alignment accuracy**. Optimised micro-geometry for increased working life and performance capability.

##### Recommendation:

##### Maximum drilling depth:

flute length (see table) less  $1.5 \times \text{nominal } \varnothing$ .

##### Note:

Flute length  $L_c = L_2 + 1.5 \times D_c$ .

For process reliability when using the  $12 \times D$  drill, an initial centre drilling with NC spotting drills No. 121068 – 121130 is necessary.

Form HB and HE are supplied at the same price as HA.

Order form **HB**: with **No. 123226**.

Order form **HE**: with **No. 123225 + 129100HE**.

Standard: Manufacturer's standard

Tolerance nominal  $\varnothing$ : h7

Number of cutting edges Z: 2

Tolerance nominal  $\varnothing$ : h7

recommended maximum drilling depth  $L_2$ : 163.7 mm

Overall length L: 230 mm

Shank  $\varnothing D_s$ : 14 mm

Feed f in steel  $< 1100 \text{ N/mm}^2$ : 0.23 mm/rev.

## Technical description

|   |                         |
|---|-------------------------|
| Feed f in steel < 1100 N/mm <sup>2</sup>          | 0.23 mm/rev.            |
| Tolerance nominal Ø                               | h7                      |
| Number of cutting edges Z                         | 2                       |
| Overall length L                                  | 230 mm                  |
| Standard  | Manufacturer's standard |
| Flute length L <sub>c</sub>                       | 182 mm                  |
| Shank Ø D <sub>s</sub>                            | 14 mm                   |
| recommended maximum drilling depth L <sub>2</sub> | 163.7 mm                |
| Nominal Ø D <sub>c</sub>                          | 12.2 mm                 |
| Series  | GARANT Master Steel     |
| Coating   | TiAlN                   |
| Tool material                                     | Solid carbide           |
| Drill depth up to                                 | 12×D                    |
| Point angle                                       | 135 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 |
|------------------------|-----------|