

Garant

GARANT Master Steel SPEED solid carbide drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7: 18,2 mm



Order data

Order number	123225 18,2
GTIN	4045197845948
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×nominal Ø.

Note:

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

For process reliability when using the 12×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 Ø: h7

Number of cutting edges Z: 2

Semi-Standard: yes

Tolerance nominal Ø: h7

recommended maximum drilling depth L_2 : 230.7 mm

Overall length L: 310 mm

Shank Ø D_s : 20 mm

Feed f in steel $< 1100 \text{ N/mm}^2$: 0.325 mm/rev.

Technical description

Standard	Manufacturer's standard
Feed f in steel $< 1100 \text{ N/mm}^2$	0.325 mm/rev.
Tolerance nominal \varnothing	h7
Number of cutting edges Z	2
recommended maximum drilling depth L_2	230.7 mm
Flute length L_c	258 mm
Shank $\varnothing D_s$	20 mm
Nominal $\varnothing D_c$	18.2 mm
Overall length L	310 mm
Semi-Standard	yes
Series	GARANT Master Steel
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	12xD
Point angle	135 degrees
Shank	DIN 6535 HA to h6
Through-coolant	yes, to 25 bar
Machining strategy	HPC
Colour ring	green
Type of product	Jobber drill

Services

Shank grinding Type HE	129100 HE
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