Hoffmann Group

Garant

GARANT Master Steel SPEED solid carbide drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7: 5,9 mm

Order data

Order number	123225 5,9
GTIN	4045197845085
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: 69.2 mm
Overall length L: 116 mm
Shank Ø D_s: 6 mm

Feed f in steel < 1100 N/mm^2: 0.125 mm/rev.

Technical description

Overall length L	116 mm
Standard	Manufacturer's standard
recommended maximum drilling depth L$_2$	69.2 mm
Flute length L$_c$	78 mm
Nominal Ø D$_c$	5.9 mm
Feed f in steel < 1100 N/mm^2	0.125 mm/rev.
Shank Ø D$_s$	6 mm
Number of cutting edges Z	2
Tolerance nominal Ø	h7
Semi-Standard	yes
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
Colour ring	green
Type of product	Jobber drill

Services

Shank grinding Type HE	129100 HE