Garant

GARANT Master Steel SPEED solid carbide drill, plain shank DIN 6535 HA, TIAIN, Ø DC h7: 6,3 mm

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Order data

Order number	123225 6,3
GTIN	4045197845122
Item class	11E

Description

Version:

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

- $\cdot\,$ 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 $1.5 \times nominal \emptyset$.

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

Tolerance nominal Ø: h7

recommended maximum drilling depth L₂: 98.6 mm

Overall length L: 146 mm

Shank Ø D_s: 8 mm

Feed f in steel < 1100 N/mm²: 0.15 mm/rev.

Technical description

Nominal Ø Dc6.3 mmFlute length Lc108 mmrecommended maximum drilling depth Lc98.6 mmNumber of cutting edges Z2StandardManufacturer's standardFeed f in steel < 1100 N/mm²0.15 mm/rev.Tolerance nominal Øh7SeriesGARANT Master SteelCoatingTiAINTool materialSolid carbideDrill depth up to12×DPoint angle135 degreesShankDIN 6535 HA to h6Through-coolantyes, to 25 barMachining strategyHPCSemi-StandardyesColour ringgreen	Overall length L	146 mm
Flute length L recommended maximum drilling depth L 2108 mmNumber of cutting edges Z98.6 mmNumber of cutting edges Z2StandardManufacturer's standardFeed f in steel < 1100 N/mm²	Shank Ø D₅	8 mm
recommended maximum drilling depth L ₂ 98.6 mm Number of cutting edges Z 2 Standard 2 Manufacturer's standard GARANT Master Steel Tolerance nominal Ø 6 Series GARANT Master Steel Coating TiAlN Coating TiAlN Coating trategi Drill depth up to 12×D Point angle 12×D Point angle 1135 degrees Shank DIN 6535 HA to h6 Through-coolant yes, to 25 bar Machining strategy HPC Semi-Standard yes	Nominal Ø D _c	6.3 mm
Number of cutting edges Z2StandardManufacturer's standardFeed f in steel < 1100 N/mm²	Flute length L _c	108 mm
StandardManufacturer's standardFeed f in steel < 1100 N/mm²	recommended maximum drilling depth L_2	98.6 mm
Feed f in steel < 1100 N/mm²0.15 mm/rev.Tolerance nominal Øh7SeriesGARANT Master SteelCoatingTiAINTool materialSolid carbideDrill depth up to12×DPoint angle135 degreesShankDIN 6535 HA to h6Through-coolantyes, to 25 barMachining strategyJyesSemi-StandardyesColour ringgreen	Number of cutting edges Z	2
Tolerance nominal Øh7SeriesGARANT Master SteelCoatingTiAlNTool materialSolid carbideDrill depth up to12×DPoint angle135 degreesShankDIN 6535 HA to h6Through-coolantyes, to 25 barMachining strategyHPCSemi-StandardyesColour ringgreen	Standard	Manufacturer's standard
SeriesGARANT Master SteelCoatingTiAINTool materialSolid carbideDrill depth up to12×DPoint angle135 degreesShankDIN 6535 HA to h6Through-coolantyes, to 25 barMachining strategyHPCSemi-StandardyesColour ringgreen	Feed f in steel < 1100 N/mm ²	0.15 mm/rev.
CoatingTiAINTool materialSolid carbideDrill depth up to12×DPoint angle135 degreesShankDIN 6535 HA to h6Through-coolantyes, to 25 barMachining strategyHPCSemi-StandardyesColour ringgreen	Tolerance nominal Ø	h7
Tool materialSolid carbideDrill depth up to12×DPoint angle135 degreesShankDIN 6535 HA to h6Through-coolantyes, to 25 barMachining strategyHPCSemi-StandardyesColour ringgreen	Series	GARANT Master Steel
Drill depth up to12×DPoint angle135 degreesShankDIN 6535 HA to h6Through-coolantyes, to 25 barMachining strategyHPCSemi-StandardyesColour ringgreen	Coating	TiAIN
Point angle135 degreesShankDIN 6535 HA to h6Through-coolantyes, to 25 barMachining strategyHPCSemi-StandardyesColour ringgreen	Tool material	Solid carbide
ShankDIN 6535 HA to h6Through-coolantyes, to 25 barMachining strategyHPCSemi-StandardyesColour ringgreen	Drill depth up to	12×D
Through-coolantyes, to 25 barMachining strategyHPCSemi-StandardyesColour ringgreen	Point angle	135 degrees
Machining strategyHPCSemi-StandardyesColour ringgreen	Shank	DIN 6535 HA to h6
Semi-Standard yes Colour ring green	Through-coolant	yes, to 25 bar
Colour ring green	Machining strategy	HPC
	Semi-Standard	yes
Type of product Jobber drill	Colour ring	green
	Type of product	Jobber drill

Services

Shank grinding Type HE	129100 HE
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