

## Garant

### GARANT Master Steel SPEED solid carbide drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7: 7,5 mm



#### Order data

|              |               |
|--------------|---------------|
| Order number | 123225 7,5    |
| GTIN         | 4045197845245 |
| 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

Tolerance nominal Ø: h7

recommended maximum drilling depth  $L_2$ : 96.8 mm

Overall length L: 146 mm

Shank Ø  $D_s$ : 8 mm

Feed f in steel < 1100 N/mm<sup>2</sup>: 0.15 mm/rev.

## Technical description

|  |                         |
|--|-------------------------|
| Tolerance nominal $\varnothing$          | h7                      |
| Number of cutting edges Z                | 2                       |
| Flute length $L_c$                       | 108 mm                  |
| Shank $\varnothing D_s$                  | 8 mm                    |
| Overall length L                         | 146 mm                  |
| recommended maximum drilling depth $L_2$ | 96.8 mm                 |
| Feed f in steel < 1100 N/mm <sup>2</sup> | 0.15 mm/rev.            |
| Nominal $\varnothing D_c$                | 7.5 mm                  |
| Standard                                 | Manufacturer's standard |
| 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                     |
| Semi-Standard                            | yes                     |
| Colour ring                              | green                   |
| Type of product                          | Jobber drill            |

## Services

|                        |           |
|------------------------|-----------|
| Shank grinding Type HE | 129100 HE |
|------------------------|-----------|