

## Garant

### GARANT Master Steel SPEED solid carbide drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7: 8,5 mm



#### Order data

Order number	123225 8,5
GTIN	4045197845344
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  $L_2$ : 107.3 mm

Overall length L: 162 mm

Shank Ø  $D_s$ : 10 mm

Feed f in steel < 1100 N/mm<sup>2</sup>: 0.18 mm/rev.

## Technical description

Shank $\varnothing D_s$	10 mm
recommended maximum drilling depth $L_2$	107.3 mm
Tolerance nominal $\varnothing$	h7
Standard	Manufacturer's standard
Nominal $\varnothing D_c$	8.5 mm
Number of cutting edges Z	2
Flute length $L_c$	120 mm
Feed f in steel < 1100 N/mm <sup>2</sup>	0.18 mm/rev.
Overall length L	162 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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