

Garant

GARANT Master Steel SPEED solid carbide drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 18 mm



Order data

| | |
|--------------|---------------|
| Order number | 123226 18 |
| GTIN | 4045197848376 |
| 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 deep-hole drill, an initial centre drilling with No. 121068 – 121130 or 3×D pilot drilling operation with No. 122736 is necessary.

Standard: Manufacturer's standard

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

Tolerance nominal Ø: h7

recommended maximum drilling depth L_2 : 207 mm

Overall length L: 285 mm

Shank Ø D_s : 18 mm

Feed f in steel < 1100 N/mm²: 0.29 mm/rev.

Technical description

| | |
|--|-------------------------|
| Nominal $\varnothing D_c$ | 18 mm |
| Feed f in steel < 1100 N/mm ² | 0.29 mm/rev. |
| Number of cutting edges Z | 2 |
| recommended maximum drilling depth L_2 | 207 mm |
| Tolerance nominal \varnothing | h7 |
| Shank $\varnothing D_s$ | 18 mm |
| Flute length L_c | 234 mm |
| Overall length L | 285 mm |
| Standard | Manufacturer's standard |
| Series | GARANT Master Steel |
| Coating | TiAlN |
| Tool material | Solid carbide |
| Drill depth up to | 12xD |
| Point angle | 135 degrees |
| Cutting direction | right-hand |
| Shank | DIN 6535 HB to h6 |
| Through-coolant | yes, to 25 bar |
| Machining strategy | HPC |
| Pilot drill required | yes, pilot drill |
| Semi-Standard | yes |
| Colour ring | green |
| Type of product | Jobber drill |