

# GARANT Master Steel SPEED solid carbide drill, Weldon shank DIN 6535 HB, TiAIN, Ø DC h7: 5,2 mm



### **Order data**

Order number	123226 5,2
GTIN	4045197847454
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  $1.5 \times \text{nominal } \emptyset$ .

#### 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<sub>2</sub>: 70.2 mm

Overall length L: 116 mm

Shank Ø D.: 6 mm

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

# **Technical description**

Standard  Manufacturer's standard  Tolerance nominal Ø  Shank Ø D₄  Feed f in steel < 1100 N/mm²  Peed f in steel < 1100 N/mm²  Nominal Ø D₂  Overall length L  Series  GARANT Master Steel  Coating  TiAlN  Tool material  Solid carbide  Drill depth up to  Point angle  Cutting direction  Shank  DIN 6535 HB to h6  Through-coolant  Manufacturer's standard  h7  Somm  0.125 mm  0.125 mm/rev.  70.2 mm  Shank  GARANT Master Steel  116 mm  Solid carbide  12×D  Point angle  135 degrees  Cutting direction  Fight-hand  Shank  DIN 6535 HB to h6  Through-coolant  Yes, to 25 bar  Machining strategy  HPC  Pilot drill required  yes, pilot drill	Number of cutting edges Z	2
Tolerance nominal Ø h7  Shank Ø D <sub>s</sub> 6 mm  Feed f in steel < 1100 N/mm² 0.125 mm/rev.  recommended maximum drilling depth L₂ 70.2 mm  Nominal Ø D <sub>c</sub> 5.2 mm  Overall length L 116 mm  Series GARANT Master Steel  Coating TiAIN  Tool material Solid carbide  Drill depth up to 12×D  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	Flute length L <sub>c</sub>	78 mm
Shank Ø D₃       6 mm         Feed f in steel < 1100 N/mm²	Standard	Manufacturer's standard
Feed f in steel < 1100 N/mm²  recommended maximum drilling depth L₂  70.2 mm  Nominal Ø D₂  5.2 mm  Overall length L  116 mm  Series  GARANT Master Steel  Coating  TiAIN  Tool material  Solid carbide  Drill depth up to  12×D  Point angle  Cutting direction  Shank  DIN 6535 HB to h6  Through-coolant  Machining strategy  HPC  Pilot drill required  90.125 mm/rev.  70.2 mm  Annum  Standar  DIN 6535 HB to h6  Through-coolant  Mechining strategy  HPC  Pilot drill required  yes, pilot drill	Tolerance nominal Ø	h7
recommended maximum drilling depth $L_2$ Nominal $\oslash$ $D_c$ Overall length L  Series  GARANT Master Steel  Coating  TiAIN  Tool material  Solid carbide  Drill depth up to  Point angle  Cutting direction  Shank  DIN 6535 HB to h6  Through-coolant  Machining strategy  Pilot drill required  70.2 mm  70.2 mm  70.2 mm  70.2 mm  70.2 mm  6186  6196  6196  Filot drill required  70.2 mm  70.2 mm  70.2 mm  70.2 mm  6196  Filot drill required  70.2 mm  70.2 mm  70.2 mm  6196  Filot drill required  70.2 mm  70.2 mm  6196  Filot drill required  70.2 mm  70.2 mm  6196  Filot drill required  70.2 mm  7	Shank Ø D <sub>s</sub>	6 mm
Nominal Ø D <sub>c</sub> Overall length L  Series  GARANT Master Steel  Coating  TiAIN  Tool material  Drill depth up to  Point angle  Cutting direction  Shank  DIN 6535 HB to h6  Through-coolant  Machining strategy  Pilot drill required  5.2 mm  5.2 mm  5.2 mm  5.2 mm  5.2 mm  DIN 6535 HB to H6  Through-coolant  yes, to 25 bar  HPC  Pilot drill required	Feed f in steel < 1100 N/mm <sup>2</sup>	0.125 mm/rev.
Overall length L  Series  GARANT Master Steel  Coating  TiAIN  Tool material  Drill depth up to  Point angle  Cutting direction  Shank  DIN 6535 HB to h6  Through-coolant  Machining strategy  Pilot drill required  116 mm  GARANT Master Steel  TiAIN  Solid carbide  12×D  12×D  135 degrees  right-hand  DIN 6535 HB to h6  HPC  Yes, to 25 bar	recommended maximum drilling depth L <sub>2</sub>	70.2 mm
Series GARANT Master Steel Coating TiAIN Tool material Solid carbide Drill depth up to 12×D 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	Nominal Ø D <sub>c</sub>	5.2 mm
Coating TiAIN  Tool material Solid carbide  Drill depth up to 12×D  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	Overall length L	116 mm
Tool material  Drill depth up to  Point angle  Cutting direction  Shank  DIN 6535 HB to h6  Through-coolant  Machining strategy  Pilot drill required  Solid carbide  12×D  135 degrees  right-hand  DIN 6535 HB to h6  yes, to 25 bar  HPC  yes, pilot drill	Series	GARANT Master Steel
Drill depth up to  Point angle Cutting direction Shank DIN 6535 HB to h6 Through-coolant Machining strategy Pilot drill required  12×D 135 degrees right-hand Pilot drill required  135 degrees right-hand Pilot drill required  yes, to 25 bar HPC yes, pilot drill	Coating	TiAIN
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	Tool material	Solid carbide
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	Drill depth up to	12×D
Shank  DIN 6535 HB to h6  Through-coolant  Machining strategy  Pilot drill required  yes, pilot drill	Point angle	135 degrees
Through-coolant yes, to 25 bar  Machining strategy HPC  Pilot drill required yes, pilot drill	Cutting direction	right-hand
Machining strategy  HPC  Pilot drill required  yes, pilot drill	Shank	DIN 6535 HB to h6
Pilot drill required yes, pilot drill	Through-coolant	yes, to 25 bar
	Machining strategy	HPC
Semi-Standard yes	Pilot drill required	yes, pilot drill
	Semi-Standard	yes
Colour ring green	Colour ring	green
Type of product Jobber drill	Type of product	Jobber drill