

# GARANT Master Steel SPEED solid carbide drill, Weldon shank DIN 6535 HB, TiAIN, Ø DC h7: 7,3 mm



### **Order data**

Order number	123226 7,3
GTIN	4045197847669
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>: 97.1 mm

Overall length L: 146 mm

Shank Ø D.: 8 mm

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

# **Technical description**

Shank Ø D₃       8 mm         Standard       Manufacturer's standard         recommended maximum drilling depth L₂       97.1 mm         Flute length L₂       108 mm         Number of cutting edges Z       2         Tolerance nominal Ø       h7         Feed f in steel < 1100 N/mm²	Nominal Ø D <sub>c</sub>	7.3 mm
Standard       Manufacturer's standard         recommended maximum drilling depth L₂       97.1 mm         Flute length Lҫ       108 mm         Number of cutting edges Z       2         Tolerance nominal Ø       h7         Feed f in steel < 1100 N/mm²	Overall length L	146 mm
recommended maximum drilling depth $L_2$ 97.1 mm  Flute length $L_c$ 108 mm  Number of cutting edges Z 2  Tolerance nominal Ø h7  Feed f in steel < 1100 N/mm² 0.15 mm/rev.  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  Semi-Standard yes  Colour ring green	Shank Ø D <sub>s</sub>	8 mm
Flute length L <sub>c</sub> Number of cutting edges Z  Tolerance nominal Ø  Feed f in steel < 1100 N/mm²  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  HPC  Pilot drill required  Semi-Standard  Cutting direen  Yes  Colour ring  108 mm  108 mm  108 mm  108 mm  108 mm  17  And  NT  And  NT  And  NT  And  NT  And  NT  And  NT  NT  And  NT  NT  NT  NT  NT  NT  NT  NT  NT  N	Standard	Manufacturer's standard
Number of cutting edges Z  Tolerance nominal Ø  h7  Feed f in steel < 1100 N/mm²  O.15 mm/rev.  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  Semi-Standard  yes  Colour ring  green	recommended maximum drilling depth L <sub>2</sub>	97.1 mm
Tolerance nominal Ø h7  Feed f in steel < 1100 N/mm² 0.15 mm/rev.  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  Semi-Standard yes  Colour ring green	Flute length L <sub>c</sub>	108 mm
Feed f in steel < 1100 N/mm²  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  Semi-Standard  Yes  Colour ring  O.15 mm/rev.  GARANT Master Steel  All Naster Steel  TiAIN  Solid carbide  12×D  Point angle  135 degrees  right-hand  DIN 6535 HB to h6  Yes, to 25 bar  HPC  yes, pilot drill  yes  Colour ring  Green	Number of cutting edges Z	2
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 Semi-Standard yes Colour ring green	Tolerance nominal Ø	h7
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 Semi-Standard yes Colour ring green	Feed f in steel < 1100 N/mm <sup>2</sup>	0.15 mm/rev.
Tool material  Drill depth up to  Point angle  Cutting direction  Shank  DIN 6535 HB to h6  Through-coolant  Machining strategy  HPC  Pilot drill required  Semi-Standard  Colour ring  Solid carbide  12×D  135 degrees  135 degrees  Pight-hand  DIN 6535 HB to h6  yes, to 25 bar  HPC  yes, pilot drill  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  HPC  Pilot drill required  Semi-Standard  Colour ring  12×D  13×D  12×D  135 degrees  right-hand  yight-hand  Pilot 6535 HB to h6  yes, to 25 bar  HPC  yes, pilot drill  yes  green	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 Semi-Standard yes Colour ring green	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  Semi-Standard yes  Colour ring green	Drill depth up to	12×D
Shank  DIN 6535 HB to h6  Through-coolant  Machining strategy  HPC  Pilot drill required  Semi-Standard  Colour ring  DIN 6535 HB to h6  yes, to 25 bar  HPC  yes, pilot drill  yes  green	Point angle	135 degrees
Through-coolant yes, to 25 bar  Machining strategy HPC  Pilot drill required yes, pilot drill  Semi-Standard yes  Colour ring green	Cutting direction	right-hand
Machining strategy  HPC  Pilot drill required  Semi-Standard  Colour ring  HPC  yes, pilot drill  yes  green	Shank	DIN 6535 HB to h6
Pilot drill required yes, pilot drill Semi-Standard yes Colour ring green	Through-coolant	yes, to 25 bar
Semi-Standard yes Colour ring green	Machining strategy	HPC
Colour ring green	Pilot drill required	yes, pilot drill
-	Semi-Standard	yes
Type of product Jobber drill	Colour ring	green
	Type of product	Jobber drill