

## Garant

**GARANT Master Steel SPEED solid carbide drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 8,5 mm**



### Order data

Order number	123226 8,5
GTIN	4045197847782
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  $L_2$ : 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
Number of cutting edges Z	2
Standard	Manufacturer's standard
Overall length L	162 mm
Flute length $L_c$	120 mm
Nominal $\varnothing D_c$	8.5 mm
Tolerance nominal $\varnothing$	h7
recommended maximum drilling depth $L_2$	107.3 mm
Feed f in steel < 1100 N/mm <sup>2</sup>	0.18 mm/rev.
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