

Garant

GARANT Master Steel FEED solid carbide drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7: 11,8 mm



Order data

Order number	123235 11,8
GTIN	4045197840998
Item class	11E

Description

Version:

3-flute drill, specially developed for **use at very high feed rates**. Outstandingly suitable for **machines with high installed power** and stable operating conditions.

- **Special cutter geometry with stable cutting edges and large clearance at the centre enables very high feed rates.**
- **The patented tip is optimised for chip flow and generates low cutting pressure with good chip breakage.**

The **sector-leading technology of the drill point** guarantees **optimum self-centring behaviour**. 3 guide chamfers guarantee a stable exit from the hole and an exact roundness of the hole.

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 an NC spotting drill No. 121130 with **155° point angle** is necessary.

Standard: Manufacturer's standard

Tolerance nominal Ø: h7

Number of cutting edges Z: 3

Tolerance nominal Ø: h7

recommended maximum drilling depth L_2 : 138.3 mm

Overall length L: 204 mm

Shank Ø D_s : 12 mm

Feed f in steel < 1100 N/mm²: 0.5 mm/rev.

Technical description

recommended maximum drilling depth L_2	138.3 mm
Flute length L_c	156 mm
Feed f in steel $< 1100 \text{ N/mm}^2$	0.5 mm/rev.
Number of cutting edges Z	3
Nominal $\varnothing D_c$	11.8 mm
Overall length L	204 mm
Shank $\varnothing D_s$	12 mm
Tolerance nominal \varnothing	h7
Standard	Manufacturer's standard
Series	GARANT Master Steel
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	12xD
Point angle	140 degrees
Shank	DIN 6535 HA to h6
Through-coolant	yes, to 25 bar
Machining strategy	HPC
Semi-Standard	yes
Colour ring	green
Type of product	Jobber drill

Services

Shank grinding Type HE	129100 HE
------------------------	-----------