

Garant

GARANT Master Steel FEED solid carbide drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7: 20 mm



Order data

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|--------------|---------------|
| Order number | 123235 20 |
| GTIN | 4045197841339 |
| 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 : 228 mm

Overall length L: 310 mm

Shank Ø D_s : 20 mm

Feed f in steel < 1100 N/mm²: 0.69 mm/rev.

Technical description

| | |
|---|-------------------------|
| Number of cutting edges Z | 3 |
| Tolerance nominal Ø | h7 |
| Standard | Manufacturer's standard |
| Flute length L _c | 258 mm |
| Overall length L | 310 mm |
| recommended maximum drilling depth L ₂ | 228 mm |
| Shank Ø D _s | 20 mm |
| Feed f in steel < 1100 N/mm ² | 0.69 mm/rev. |
| Nominal Ø D _c | 20 mm |
| Series | GARANT Master Steel |
| Coating | TiAlN |
| Tool material | Solid carbide |
| Drill depth up to | 12×D |
| 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

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