

Garant
GARANT Master Steel FEED solid carbide drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7 (mm or inch): 13/32

Order data

Order number	123035 13/32
GTIN	4062406112400
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 $1.5 \times \text{nominal } \varnothing$.

Note:

Flute length $L_c = L_2 + 1.5 \times D_c$.

Form HB and HE supplied at the same price as HA.

Form **HB**: order with **No. 123036**.

Form **HE**: order with **No. 123035 + 129100HE**.

Standard: Manufacturer's standard

Tolerance nominal \varnothing : h7

Number of cutting edges Z: 3

Tolerance nominal \varnothing : h7

recommended maximum drilling depth L_2 : 98.4 mm

Overall length L: 162 mm

Shank $\varnothing D_s$: 12 mm

Feed f in steel $< 1100 \text{ N/mm}^2$: 0.5 mm/rev.

Technical description

Feed f in steel < 1100 N/mm ²	0.5 mm/rev.
recommended maximum drilling depth L ₂	98.4 mm
Overall length L	162 mm
Standard	Manufacturer's standard
Number of cutting edges Z	3
Flute length L _c	114 mm
Shank Ø D _s	12 mm
Tolerance nominal Ø	h7
Inch nominal Ø corresponds to	10,32 mm
Series	GARANT Master Steel
Coating	TiAlN
Tool material	Solid carbide
	8×D
Point angle	140°
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

User data

	Suitability	V _c	ISO code
Steel < 500 N/mm ²	suitable	120 m/min	P
Steel < 750 N/mm ²	suitable	110 m/min	P
Steel < 900 N/mm ²	suitable	100 m/min	P
Steel < 1100 N/mm ²	suitable	90 m/min	P

Steel < 1400 N/mm ²	suitable	70 m/min	P
Steel < 55 HRC	suitable	60 m/min	H
INOX < 900 N/mm ²	suitable	55 m/min	M
INOX > 900 N/mm ²	suitable	50 m/min	M
Ti > 850 N/mm ²	suitable only under restricted conditions	40 m/min	S
GG	suitable	120 m/min	K
GGG	suitable	80 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable		
Services			

Shank grinding Type HE

129100 HE