Garant

GARANT Master Steel SPEED solid carbide drill, plain shank DIN 6535 HA, TiAlN, ⌀ DC h7: 4,4mm

Order data

Order number	122415 4,4
GTIN	4045197783950
Item class	11E

Description

Version:
Developed for use with **very high cutting speeds**. Outstandingly suitable for machines with **low power output** 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 edge** 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.
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. 122416**.
Form **HE:** order with **No. 122415 + 129100HE**.

Technical description

Number of cutting edges Z	2
Tolerance nominal ⌀	h7
Shank ⌀ D_s	6 mm
Feed f in steel < 1100 N/mm^2	0.16 mm/rev.
Flute length L_c	24 mm
Nominal ⌀ D_C	4.4 mm

Overall length L	66 mm
Shank tolerance	h6
Standard	DIN 6537 K
recommended maximum drilling depth L_2	17.4 mm
Series	Master Steel
Coating	TiAlN
Tool material	solid carbide
Version	4×D
Point angle	135 degrees
Shank	DIN 6535 HA to h6
Through-coolant	no
Machining strategy	HPC
Semi-Standard	yes
Colour ring	green
Type of product	Jobber drill

User data

	Suitability	V_c	ISO code
Steel < 500 N/mm²	suitable	170 m/min	P
Steel < 750 N/mm²	suitable	150 m/min	P
Steel < 900 N/mm²	suitable	120 m/min	P
Steel < 1100 N/mm²	suitable	110 m/min	P
Steel < 1400 N/mm²	suitable only under restricted conditions	60 m/min	P
GG	suitable	110 m/min	K
GGG	suitable	100 m/min	K
Uni	suitable		
wet maximum	suitable		

Services

Shank grinding Type HE	129100 HE