

Garant
GARANT Master Steel SPEED solid carbide drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7: 15,2mm

Order data

Order number	122415 15,2
GTIN	4045197784841
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

Tolerance nominal Ø	h7
Shank tolerance	h6
Flute length L_c	65 mm
Standard	DIN 6537 K
Number of cutting edges Z	2
Overall length L	115 mm

Shank $\varnothing D_s$	16 mm
Nominal $\varnothing D_c$	15.2 mm
Feed f in steel $< 1100 \text{ N/mm}^2$	0.34 mm/rev.
recommended maximum drilling depth L_2	42.2 mm
Series	Master Steel
Coating	TiAlN
Tool material	solid carbide
Version	4xD
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 $< 500 \text{ N/mm}^2$	suitable	170 m/min	P
Steel $< 750 \text{ N/mm}^2$	suitable	150 m/min	P
Steel $< 900 \text{ N/mm}^2$	suitable	120 m/min	P
Steel $< 1100 \text{ N/mm}^2$	suitable	110 m/min	P
Steel $< 1400 \text{ N/mm}^2$	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