

Garant

GARANT Master Steel SPEED solid carbide drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7: 10,6mm



Order data

| | |
|--------------|---------------|
| Order number | 122425 10,6 |
| GTIN | 4045197785893 |
| 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 $L_c = L_2 + 1.5 \times D_c$.

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

Form **HB**: state **No.122426** on the order.

Form **HE**: order with **No.122425 + 129100HE**.

Technical description

| | |
|---------------------------|---------|
| Shank Ø D _s | 12 mm |
| Shank tolerance | h6 |
| Overall length L | 102 mm |
| Nominal Ø D _c | 10.6 mm |
| Number of cutting edges Z | 2 |
| Tolerance nominal Ø | h7 |

| | |
|---|-------------------|
| Flute length L_c | 55 mm |
| Standard | DIN 6537 K |
| Feed f in steel $< 1100 \text{ N/mm}^2$ | 0.28 mm/rev. |
| recommended maximum drilling depth L_2 | 39.1 mm |
| Series | Master Steel |
| Coating | TiAlN |
| Tool material | solid carbide |
| Version | 4xD |
| Point angle | 135 degrees |
| Shank | DIN 6535 HA to h6 |
| Through-coolant | yes, with 25 bar |
| Machining strategy | HPC |
| Semi-Standard | yes |
| Colour ring | green |
| Type of product | Jobber drill |

User data

| | Suitability | V_c | ISO code |
|-------------------------------|---|-----------|----------|
| Steel $< 500 \text{ N/mm}^2$ | suitable | 220 m/min | P |
| Steel $< 750 \text{ N/mm}^2$ | suitable | 200 m/min | P |
| Steel $< 900 \text{ N/mm}^2$ | suitable | 180 m/min | P |
| Steel $< 1100 \text{ N/mm}^2$ | suitable | 170 m/min | P |
| Steel $< 1400 \text{ N/mm}^2$ | suitable | 90 m/min | P |
| INOX $< 900 \text{ N/mm}^2$ | suitable only under restricted conditions | 75 m/min | M |
| GG | suitable | 160 m/min | K |
| GGG | suitable | 130 m/min | K |
| Uni | suitable | | |
| wet maximum | suitable | | |

wet minimum
Services

suitable

Shank grinding Type HE

129100 HE