

Garant

GARANT Master Steel SPEED solid carbide drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7: 8,5mm



Order data

Order number	122715 8,5
GTIN	4045197788221
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. 122716**.

Form **HE**: order with **No. 122715 + 129100HE**.

Technical description

Nominal Ø D_c	8.5 mm
Number of cutting edges Z	2
Shank Ø D_s	10 mm
Standard	DIN 6537
Flute length L_c	61 mm
Tolerance nominal Ø	h7

Feed f in steel < 1100 N/mm ²	0.26 mm/rev.
Overall length L	103 mm
recommended maximum drilling depth L ₂	48.3 mm
Series	Master Steel
Coating	TiAlN
Tool material	solid carbide
Version	6×D
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 N/mm ²	suitable	220 m/min	P
Steel < 750 N/mm ²	suitable	200 m/min	P
Steel < 900 N/mm ²	suitable	180 m/min	P
Steel < 1100 N/mm ²	suitable	170 m/min	P
Steel < 1400 N/mm ²	suitable	90 m/min	P
INOX < 900 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	suitable		

Services

Shank grinding Type HE

129100 HE