

## Garant

**GARANT Master Steel SPEED solid carbide drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7: 18,8 mm**



### Order data

Order number	122715 18,8
GTIN	4045197788849
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.

#### Recommendation:

#### Maximum drilling depth:

flute length (see table) less 1.5×nominal Ø.

#### 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**.

Standard: DIN 6537

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

Tolerance nominal Ø: h7

recommended maximum drilling depth  $L_2$ : 72.8 mm

Overall length L: 153 mm

Shank Ø  $D_s$ : 20 mm

Feed f in steel < 1100 N/mm<sup>2</sup>: 0.38 mm/rev.

### Technical description

Overall length L	153 mm
Number of cutting edges Z	2
Flute length L <sub>c</sub>	101 mm
Nominal Ø D <sub>c</sub>	18.8 mm
Standard	DIN 6537
Feed f in steel < 1100 N/mm <sup>2</sup>	0.38 mm/rev.
Shank Ø D <sub>s</sub>	20 mm
Tolerance nominal Ø	h7
recommended maximum drilling depth L <sub>2</sub>	72.8 mm
Series	GARANT Master Steel
Coating	TiAlN
Tool material	solid carbide
	6×D
Point angle	135 °
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 <sub>c</sub>	ISO code
Steel < 500 N/mm <sup>2</sup>	suitable	220 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	200 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	180 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	170 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	90 m/min	P

INOX < 900 N/mm <sup>2</sup>	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		
<b>Services</b>			

Shank grinding Type HE

129100 HE