

Garant

GARANT Master Steel FEED solid carbide drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7 (mm or inch): 8,5



Order data

Order number	122725 8,5
GTIN	4045197789341
Item class	11E

Description

Version:

3-flute drill, specially developed for use at **very high feed rates**. Outstandingly suitable for **machines with high installed power** and stable operating conditions.

- **Special cutter geometry with stable cutting edges and large clearance at the centre enables very high feed rates.**
- **The patented tip is optimised for chip flow and generates low cutting pressure with good chip breakage.**
- **With 145° tip angle for low burr formation when drilling through holes.**

The **sector-leading technology of the chisel edge** guarantees **optimum self-centring behaviour** and permits spot drilling on irregular surfaces. 3 guide chamfers guarantee a stable exit from the hole and an exact roundness of the hole.

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. 122726**.

Form **HE**: order with **No. 122725 + 129100HE**.

Standard: DIN 6537

Tolerance nominal Ø: h7

Number of cutting edges Z: 3

Tolerance nominal Ø: h7

recommended maximum drilling depth L_2 : 48.3 mm

Overall length L: 103 mm

Shank Ø D_s : 10 mm

Feed f in steel < 1100 N/mm²: 0.44 mm/rev.

Technical description

Nominal $\varnothing D_c$	8.5 mm
Shank $\varnothing D_s$	10 mm
Flute length L_c	61 mm
Standard	DIN 6537
Number of cutting edges Z	3
Tolerance nominal \varnothing	h7
Feed f in steel < 1100 N/mm ²	0.44 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	6xD
Point angle	145 °
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	160 m/min	P
Steel < 750 N/mm ²	suitable	140 m/min	P
Steel < 900 N/mm ²	suitable	130 m/min	P
Steel < 1100 N/mm ²	suitable	110 m/min	P
Steel < 1400 N/mm ²	suitable	90 m/min	P
Steel < 55 HRC	suitable	60 m/min	H

INOX < 900 N/mm ²	suitable	60 m/min	M
INOX > 900 N/mm ²	suitable	50 m/min	M
Ti > 850 N/mm ²	suitable only under restricted conditions	40 m/min	S
GG	suitable	130 m/min	K
GGG	suitable	80 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable		

Services

Shank grinding Type HE

129100 HE