Garant

GARANT Master Steel FEED solid carbide drill, plain shank DIN 6535 HA, TIAIN, Ø DC h7 (mm or inch): 10,9

and III

Order data

Order number	122725 10,9
GTIN	4045197789587
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 : 54.7 mm Overall length L: 118 mm Shank Ø D_s: 12 mm Feed f in steel < 1100 N/mm²: 0.5 mm/rev.

Technical description

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Data sheet

Flute length Lc71 mmStandardDIN 6537Number of cutting edges Z3Feed f in steel < 1100 N/mm²0.5 mm/rev.Shank Ø D,12 mmOverall length L118 mmNominal Ø Dc10.9 mmrecommended maximum drilling depth L254.7 mmSeriesMaster SteelCoatingTiAINTool materialSolid carbideVersion6×DPoint angle145 °ShankDIN 6535 HA to h6Through-coolantyes, with 25 barMachining strategyHPCSemi-StandardyesColour ringJobber drill	Tolerance nominal \varnothing	h7		
Number of cutting edges Z3Feed f in steel < 1100 N/mm²	Flute length L _c	71 mm		
Feed f in steel < 1100 N/mm²0.5 mm/rev.Shank Ø Ds12 mmOverall length L118 mmNominal Ø Dc10.9 mmrecommended maximum drilling depth L254.7 mmSeriesMaster SteelCoatingTiAlNTool material6×DVersion6×DPoint angle145 °ShankDIN 6535 HA to h6Through-coolantyes, with 25 barMachining strategyHPCSemi-StandardyesColour ringgreen	Standard	DIN 6537		
Shank Ø D,12 mmOverall length L118 mmNominal Ø Dc10.9 mmrecommended maximum drilling depth L254.7 mmSeriesMaster SteelCoatingTiAINTool materialSolid carbideVersion6×DPoint angle145°ShankDIN 6535 HA to h6Through-coolantyes, with 25 barMachining strategyHPCSemi-StandardyesColour ringgreen	Number of cutting edges Z	3		
Overall length L118 mmNominal Ø Dc10.9 mmrecommended maximum drilling depth L254.7 mmSeriesMaster SteelCoatingTiAINTool materialsolid carbideVersion6×DPoint angle145 °ShankDIN 6535 HA to h6Through-coolantyes, with 25 barMachining strategyHPCSemi-StandardyesColour ringgreen	Feed f in steel < 1100 N/mm ²	0.5 mm/rev.		
Nominal Ø Dc10.9 mmrecommended maximum drilling depth L254.7 mmSeriesMaster SteelCoatingTiAINTool materialSolid carbideVersion6×DPoint angle145 °ShankDIN 6535 HA to h6Through-coolantyes, with 25 barMachining strategyHPCSemi-StandardyesColour ringgreen	Shank Ø D _s	12 mm		
recommended maximum drilling depth L ₂ 54.7 mm Series Master Steel Coating TiAlN Tool material Solid carbide Version 6×D Point angle 145 ° Shank DIN 6535 HA to h6 Through-coolant yes, with 25 bar Machining strategy HPC Semi-Standard yes Colour ring Green	Overall length L	118 mm		
SeriesMaster SteelCoatingTiAINTool materialsolid carbideVersion6×DPoint angle145°ShankDIN 6535 HA to h6Through-coolantyes, with 25 barMachining strategyHPCSemi-StandardyesColour ringgreen	Nominal Ø D _c	10.9 mm		
CoatingTiAINTool materialSolid carbideVersion6×DPoint angle145°ShankDIN 6535 HA to h6Through-coolantyes, with 25 barMachining strategyHPCSemi-StandardyesColour ringgreen	recommended maximum drilling depth L_2	54.7 mm		
Tool materialsolid carbideVersion6×DPoint angle145 °ShankDIN 6535 HA to h6Through-coolantyes, with 25 barMachining strategyHPCSemi-StandardyesColour ringgreen	Series	Master Steel		
Version6×DPoint angle145°ShankDIN 6535 HA to h6Through-coolantyes, with 25 barMachining strategyHPCSemi-StandardyesColour ringgreen	Coating	TiAIN		
Point angle145°ShankDIN 6535 HA to h6Through-coolantyes, with 25 barMachining strategyHPCSemi-StandardyesColour ringgreen	Tool material	solid carbide		
ShankDIN 6535 HA to h6Through-coolantyes, with 25 barMachining strategyHPCSemi-StandardyesColour ringgreen	Version	6×D		
Through-coolantyes, with 25 barMachining strategyHPCSemi-StandardyesColour ringgreen	Point angle	145 °		
Machining strategyHPCSemi-StandardyesColour ringgreen	Shank	DIN 6535 HA to h6		
Semi-Standard yes Colour ring green	Through-coolant	yes, with 25 bar		
Colour ring green	Machining strategy	HPC		
	Semi-Standard	yes		
Type of product Jobber drill	Colour ring	green		
	Type of product	Jobber drill		

User data

	Suitability	V _c	ISO code
Steel < 500 N/mm ²	suitable	160 m/min	Р
Steel < 750 N/mm ²	suitable	140 m/min	Р
Steel < 900 N/mm ²	suitable	130 m/min	Р
Steel < 1100 N/mm ²	suitable	110 m/min	Р
Steel < 1400 N/mm ²	suitable	90 m/min	Р
Steel < 55 HRC	suitable	60 m/min	Н

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INOX < 900 N/mm ²	suitable	60 m/min	М
INOX > 900 N/mm ²	suitable	50 m/min	М
Ti > 850 N/mm²	suitable only under restricted conditions	40 m/min	S
GG	suitable	130 m/min	К
GGG	suitable	80 m/min	К
Uni	suitable		
wet maximum	suitable		
wet minimum Services	suitable		

Shank grinding Type HE

129100 HE