

## Garant

**GARANT Master Steel FEED solid carbide drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7 (mm or inch): 15**



### Order data

|              |               |
|--------------|---------------|
| Order number | 122725 15     |
| GTIN         | 4045197789815 |
| 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  $L_2$ : 60.5 mm

Overall length L: 133 mm

Shank Ø  $D_s$ : 16 mm

Feed  $f$  in steel < 1100 N/mm<sup>2</sup>: 0.61 mm/rev.

### Technical description

|  |                   |
|--|-------------------|
| Number of cutting edges Z                | 3                 |
| Nominal $\varnothing D_c$                | 15 mm             |
| Shank $\varnothing D_s$                  | 16 mm             |
| Tolerance nominal $\varnothing$          | h7                |
| Standard                                 | DIN 6537          |
| Flute length $L_c$                       | 83 mm             |
| Overall length L                         | 133 mm            |
| Feed f in steel < 1100 N/mm <sup>2</sup> | 0.61 mm/rev.      |
| recommended maximum drilling depth $L_2$ | 60.5 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 <sup>2</sup>  | suitable    | 160 m/min | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable    | 140 m/min | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable    | 130 m/min | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable    | 110 m/min | P        |
| Steel < 1400 N/mm <sup>2</sup> | suitable    | 90 m/min  | P        |
| Steel < 55 HRC                 | suitable    | 60 m/min  | H        |

|                              |   |           |   |
|------------------------------|---|-----------|---|
| INOX < 900 N/mm <sup>2</sup> | suitable                                  | 60 m/min  | M |
| INOX > 900 N/mm <sup>2</sup> | suitable                                  | 50 m/min  | M |
| Ti > 850 N/mm <sup>2</sup>   | 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