

## Garant

**GARANT Master Steel solid carbide HPC drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7: 3,5mm**



### Order data

|              |               |
|--------------|---------------|
| Order number | 122475 3,5    |
| GTIN         | 4067263120520 |
| Item class   | 11E           |

### Description

#### Version:

**Robust drill design and optimised special point geometry** for the **best possible chip formation and reliable chip breakage** with **higher feed rates at the same time**. **Advanced micro-geometry, convex cutting edge and conical profile grinding** to provide additional stability for the main cutting edge. **Optimised flute geometry and patented face geometry** for **reliable chip evacuation** in steel materials and cast material. **High-performance coating** of the latest generation.

#### Note:

Flute length  $L_c = L_2 + 1.5 \times D_c$ .

HB and HE shanks are available at the same price as HA.

**HB shank:** order with **No. 122471 / 122476**.

**HE shank:** order with **No. 122470 / 122475** and **129100HE**.

### Technical description

|   |              |
|---|--------------|
| Nominal $\varnothing D_c$                 | 3.5 mm       |
| Feed $f$ in steel $< 1100 \text{ N/mm}^2$ | 0.13 mm/rev. |
| Tolerance nominal $\varnothing$           | h7           |
| Shank $\varnothing D_s$                   | 6 mm         |
| Flute length $L_c$                        | 20 mm        |
| Standard                                  | DIN 6537 K   |
| recommended maximum drilling depth $L_2$  | 14.8 mm      |

|                           |                     |
|---------------------------|---------------------|
| Overall length L          | 62 mm               |
| Number of cutting edges Z | 2                   |
| Series                    | Master Steel        |
| Coating                   | TiAlN               |
| Tool material             | Solid carbide       |
| Version                   | 4xD                 |
| Point angle               | 140 degrees         |
| Shank                     | DIN 6535 HA with h6 |
| Through-coolant           | yes, with 25 bar    |
| Machining strategy        | HPC                 |
| Semi-Standard             | yes                 |
| Colour ring               | green               |
| Type of product           | Mono jobber drills  |

## User data

|                                | Suitability                               | V <sub>c</sub> | ISO code |
|--------------------------------|---|----------------|----------|
| Steel < 500 N/mm <sup>2</sup>  | suitable                                  | 170 m/min      | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable                                  | 155 m/min      | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable                                  | 145 m/min      | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable                                  | 130 m/min      | P        |
| Steel < 1400 N/mm <sup>2</sup> | suitable                                  | 110 m/min      | P        |
| Steel < 55 HRC                 | suitable                                  | 60 m/min       | H        |
| INOX < 900 N/mm <sup>2</sup>   | suitable only under restricted conditions | 55 m/min       | M        |
| INOX > 900 N/mm <sup>2</sup>   | suitable only under restricted conditions | 45 m/min       | M        |
| GG                             | suitable                                  | 130 m/min      | K        |
| GGG                            | suitable                                  | 90 m/min       | K        |
| Uni                            | suitable                                  |                |          |

|             |          |
|-------------|----------|
| wet maximum | suitable |
| wet minimum | suitable |
| Air         | suitable |