

Garant

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



Order data

| | |
|--------------|---------------|
| Order number | 122475 3 |
| GTIN | 4067263120476 |
| 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

| | |
|---|--------------|
| recommended maximum drilling depth L_2 | 15.5 mm |
| Feed f in steel $< 1100 \text{ N/mm}^2$ | 0.12 mm/rev. |
| Overall length L | 62 mm |
| Tolerance nominal \varnothing | h7 |
| Number of cutting edges Z | 2 |
| Standard | DIN 6537 K |
| Shank $\varnothing D_s$ | 6 mm |

| | |
|---------------------------|---------------------|
| Nominal $\varnothing D_c$ | 3 mm |
| Flute length L_c | 20 mm |
| 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_c | ISO code |
|--------------------------------|---|-----------|----------|
| Steel < 500 N/mm ² | suitable | 170 m/min | P |
| Steel < 750 N/mm ² | suitable | 155 m/min | P |
| Steel < 900 N/mm ² | suitable | 145 m/min | P |
| Steel < 1100 N/mm ² | suitable | 130 m/min | P |
| Steel < 1400 N/mm ² | suitable | 110 m/min | P |
| Steel < 55 HRC | suitable | 60 m/min | H |
| INOX < 900 N/mm ² | suitable only under restricted conditions | 55 m/min | M |
| INOX > 900 N/mm ² | suitable only under restricted conditions | 45 m/min | M |
| GG | suitable | 130 m/min | K |
| GGG | suitable | 90 m/min | K |
| Uni | suitable | | |

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