

Garant**GARANT Master Steel solid carbide high-performance drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7: 6,6mm****Order data**

Order number	123240 6,6
GTIN	4069515030427
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 $L_c = L_2 + 1.5 \times D_c$.

For process reliability when using the 12xD drill, an initial centre drilling with No. 121068 – 121130 is recommended.

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

For **HB shanks**: use order **no. 123241**.

For **HE shanks**: use order **No. 123240 + 129100HE**.

Technical description

Number of cutting edges Z	2
Tolerance nominal Ø	h7
Flute length L_c	108 mm
Overall length L	146 mm
Shank Ø D_s	8 mm
Nominal Ø D_c	6.6 mm

Data sheet

recommended maximum drilling depth L_2	98.1 mm
Standard	Works standard
Feed f in steel $< 1100 \text{ N/mm}^2$	0.19 mm/rev.
Series	Master Steel
Coating	TiAlN
Tool material	Solid carbide
Version	12xD
Point angle	135 degrees
Shank	DIN 6535 HA to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Semi-Standard	yes
Type of product	Jobber drill

User data

	Suitability	V_c	ISO code
Steel $< 500 \text{ N/mm}^2$	suitable	130 m/min	P
Steel $< 750 \text{ N/mm}^2$	suitable	120 m/min	P
Steel $< 900 \text{ N/mm}^2$	suitable	110 m/min	P
Steel $< 1100 \text{ N/mm}^2$	suitable	100 m/min	P
Steel $< 1400 \text{ N/mm}^2$	suitable	80 m/min	P
GG(G)	suitable	95 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable		
Air	suitable		

Suitable products

No Shop URL available for: 123240 6,6

