Garant

GARANT Master Steel FEED solid carbide drill, plain shank DIN 6535 HA, TIAIN, Ø DC h7 (mm or inch): 5,8

Order data

Order number	123035 5,8
GTIN	4045197839275
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.

The sector-leading technology of the drill point guarantees optimum self-centring behaviour. 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. 123036**. Form **HE**: order with **No. 123035 + 129100HE**. Standard: Manufacturer's standard Tolerance nominal \emptyset : h7 Number of cutting edges Z: 3 Tolerance nominal \emptyset : h7 recommended maximum drilling depth L_2 : 48.3 mm Overall length L: 95 mm Shank \emptyset D_s: 6 mm Feed f in steel < 1100 N/mm²: 0.32 mm/rev.

Technical description

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StandardManufacturer's standardShank Ø D,6 mmNominal Ø Dc5.8 mmTolerance nominal Øh7recommended maximum drilling depth L248.3 mmFlute length Lc57 mmFlute length Lc0.32 mm/rev.SeriesMaster SteelCoatingTiAlNTool materialSolid carbideVersion8×DPoint angle140 °ShankDIN 6535 HA to h6Through-coolantyes, to 25 barMachining strategyyesSemi-StandardyesColour ringgreen	Overall length L	95 mm		
Shank Ø D,6 mmNominal Ø Dc5.8 mmTolerance nominal Øh7recommended maximum drilling depth L248.3 mmFlute length Lc57 mmFlute length L100 N/mm²0.32 mm/rev.SeriesMaster SteelCoatingTiAINTool materialSolid carbideVersion8×DPoint angle140°ShankDIN 6535 HA to h6Through-coolantyes, to 25 barMachining strategyHPCSemi-StandardyesColour ringgreen	Number of cutting edges Z	3		
Nominal Ø Dc5.8 mmTolerance nominal Øh7Tolerance nominal Øh7recommended maximum drilling depth L248.3 mmFlute length L457 mmFlute length L40.32 mm/rev.Feed f in steel < 1100 N/mm²	Standard	Manufacturer's standard		
Tolerance nominal Øh7Tolerance nominal Øh7recommended maximum drilling depth L248.3 mmFlute length L457 mmFlute length L40.32 mm/rev.Feed f in steel < 1100 N/mm2	Shank Ø D _s	6 mm		
recommended maximum drilling depth L ₂ 48.3 mm Flute length L _c 57 mm Feed f in steel < 1100 N/mm ² 0.32 mm/rev. Series 0.32 mm/rev. Series 0.32 mm/rev. Series 0.32 mm/rev. Master Steel 0.32 mm/rev. Series 0.32 mm/rev. Master Steel 0.32 mm/rev. Solid carbide 0.32 mm/rev	Nominal Ø D _c	5.8 mm		
Flute length L Feed f in steel < 1100 N/mm²57 mmFeed f in steel < 1100 N/mm²	Tolerance nominal Ø	h7		
Feed f in steel < 1100 N/mm²0.32 mm/rev.SeriesMaster SteelCoatingTiAINTool materialSolid carbideVersion8×DPoint angle140°ShankDIN 6535 HA to h6Through-coolantyes, to 25 barMachining strategyHPCSemi-StandardyesColour ringgreen	recommended maximum drilling depth L_2	48.3 mm		
SeriesMaster SteelCoatingTiAINTool materialSolid carbideVersion8×DPoint angle140°ShankDIN 6535 HA to h6Through-coolantyes, to 25 barMachining strategyHPCSemi-StandardyesColour ringgreen	Flute length L _c	57 mm		
CoatingTiAINTool materialSolid carbideVersion8×DPoint angle140°ShankDIN 6535 HA to h6Through-coolantyes, to 25 barMachining strategyHPCSemi-StandardyesColour ringgreen	Feed f in steel < 1100 N/mm ²	0.32 mm/rev.		
Tool materialSolid carbideVersionSolid carbidePoint angle140°ShankDIN 6535 HA to h6Through-coolantyes, to 25 barMachining strategyHPCSemi-StandardyesColour ringgreen	Series	Master Steel		
Version8×DPoint angle140°ShankDIN 6535 HA to h6Through-coolantyes, to 25 barMachining strategyHPCSemi-StandardyesColour ringgreen	Coating	TiAIN		
Point angle140°ShankDIN 6535 HA to h6Through-coolantyes, to 25 barMachining strategyHPCSemi-StandardyesColour ringgreen	Tool material	Solid carbide		
Shank DIN 6535 HA to h6 Through-coolant yes, to 25 bar Machining strategy HPC Semi-Standard yes Colour ring green	Version	8×D		
Through-coolantyes, to 25 barMachining strategyHPCSemi-StandardyesColour ringgreen	Point angle	140 °		
Machining strategyHPCSemi-StandardyesColour ringgreen	Shank	DIN 6535 HA to h6		
Semi-Standard yes Colour ring green	Through-coolant	yes, to 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	120 m/min	Р
Steel < 750 N/mm ²	suitable	110 m/min	Р
Steel < 900 N/mm ²	suitable	100 m/min	Р
Steel < 1100 N/mm ²	suitable	90 m/min	Р
Steel < 1400 N/mm ²	suitable	70 m/min	Р
Steel < 55 HRC	suitable	60 m/min	Н

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INOX < 900 N/mm ²	suitable	55 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	120 m/min	К
GGG	suitable	80 m/min	К
Uni	suitable		
wet maximum	suitable		
wet minimum Services	suitable		

Shank grinding Type HE

129100 HE