Garant

GARANT Master Steel FEED solid carbide drill, plain shank DIN 6535 HA, TiAlN, ⌀ DC h7 (mm or inch): 18,5

Order data

Order number	123035 18,5
GTIN	4045197840158
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 ⌀: h7
Number of cutting edges Z: 3
Tolerance nominal ⌀: h7
recommended maximum drilling depth L_2: 162.3 mm
Overall length L: 243 mm
Shank ⌀ D_s: 20 mm
Feed f in steel < 1100 N/mm^2: 0.69 mm/rev.

Technical description

recommended maximum drilling depth L_2	162.3 mm
Feed f in steel < 1100 N/mm²	0.69 mm/rev.
Overall length L	243 mm
Flute length L_c	190 mm
Shank ⌀ D_s	20 mm
Number of cutting edges Z	3
Standard	Manufacturer's standard
Nominal ⌀ D_C	18.5 mm
Tolerance nominal ⌀	h7
Series	Master Steel
Coating	TiAlN
Tool material	Solid carbide
Version	8×D
Point angle	140 °
Shank	DIN 6535 HA to h6
Through-coolant	yes, to 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/mm²	suitable	120 m/min	P
Steel < 750 N/mm²	suitable	110 m/min	P
Steel < 900 N/mm²	suitable	100 m/min	P
Steel < 1100 N/mm²	suitable	90 m/min	P
Steel < 1400 N/mm²	suitable	70 m/min	P
Steel < 55 HRC	suitable	60 m/min	H

INOX < 900 N/mm²	suitable	55 m/min	M
INOX > 900 N/mm²	suitable	50 m/min	M
Ti > 850 N/mm²	suitable only under restricted conditions	40 m/min	S
GG	suitable	120 m/min	K
GGG	suitable	80 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable		

Services

Shank grinding Type HE	129100 HE