ᵒᵢᵒ Hoffmann Group

Garant

GARANT Master Steel FEED solid carbide drill, plain shank DIN 6535 HA, TiAlN, ∅ DC h7: 4,2mm

Order data

Order number	123235 4,2
GTIN	4045197840233
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 $L_c = L_2 + 1.5 \times D_c$.

For process reliability when using the 12×D drill, an initial centre drilling with an NC spotting drill No. 121130 with **155° point angle** is necessary.

Technical description

recommended maximum drilling depth L_2	57.7 mm
Number of cutting edges Z	3
Shank ∅ D_s	6 mm
Tolerance nominal ∅	h7
Overall length L	102 mm
Nominal ∅ D_c	4.2 mm

Flute length L_c	64 mm
Feed f in steel < 1100 N/mm^2	0.28 mm/rev.
Standard	Manufacturer's standard
Series	Master Steel
Coating	TiAlN
Tool material	Solid carbide
Version	12×D
Point angle	140 degrees
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/mm^2	suitable	120 m/min	P
Steel < 750 N/mm^2	suitable	110 m/min	P
Steel < 900 N/mm^2	suitable	100 m/min	P
Steel < 1100 N/mm^2	suitable	90 m/min	P
Steel < 1400 N/mm^2	suitable	70 m/min	P
Steel < 55 HRC	suitable	60 m/min	H
INOX < 900 N/mm^2	suitable	55 m/min	M
INOX > 900 N/mm^2	suitable	50 m/min	M
Ti > 850 N/mm^2	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