

Garant
GARANT Master Steel FEED solid carbide drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7: 16,8mm

Order data

Order number	123235 16,8
GTIN	4045197841209
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 12xD drill, an initial centre drilling with an NC spotting drill No. 121130 with **155° point angle** is necessary.

Technical description

Number of cutting edges Z	3
recommended maximum drilling depth L_2	208.8 mm
Overall length L	285 mm
Tolerance nominal Ø	h7
Nominal Ø D_c	16.8 mm
Flute length L_c	234 mm

Standard	Manufacturer's standard
Shank $\varnothing D_s$	18 mm
Feed f in steel $< 1100 \text{ N/mm}^2$	0.66 mm/rev.
Series	Master Steel
Coating	TiAlN
Tool material	Solid carbide
Version	12xD
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 $< 500 \text{ N/mm}^2$	suitable	120 m/min	P
Steel $< 750 \text{ N/mm}^2$	suitable	110 m/min	P
Steel $< 900 \text{ N/mm}^2$	suitable	100 m/min	P
Steel $< 1100 \text{ N/mm}^2$	suitable	90 m/min	P
Steel $< 1400 \text{ N/mm}^2$	suitable	70 m/min	P
Steel $< 55 \text{ HRC}$	suitable	60 m/min	H
INOX $< 900 \text{ N/mm}^2$	suitable	55 m/min	M
INOX $> 900 \text{ N/mm}^2$	suitable	50 m/min	M
Ti $> 850 \text{ N/mm}^2$	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
------------------------	-----------