

Garant

GARANT Master Steel FEED solid carbide drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 11,9mm



Order data

Order number	123236 11,9
GTIN	4045197843241
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 machining 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 deep-hole drill, an initial centre drilling with an NC spotting drill No. 121130 with **155° point angle** is necessary.

Technical description

Feed f in steel < 1100 N/mm ²	0.5 mm/rev.
Shank Ø D _s	12 mm
Number of cutting edges Z	3
Overall length L	204 mm
Nominal Ø D _c	11.9 mm
recommended maximum drilling depth L ₂	138.2 mm

Flute length L_c	156 mm
Tolerance nominal \varnothing	h7
Standard	Manufacturer's standard
Series	Master Steel
Coating	TiAlN
Tool material	Solid carbide
Version	12xD
Point angle	140 degrees
Shank	DIN 6535 HB 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