

Garant
GARANT Master Steel SPEED solid carbide drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7: 18mm

Order data

Order number	123025 18
GTIN	4045197844712
Item class	11E

Description
Version:

Developed for use with **very high cutting speeds**. Outstandingly suitable for machines with **low installed power** and high speeds.

- **Clear reduction in cutting forces due to special cutter geometry.**
- **Coating for best wear resistance even at high process temperatures.**
- **Polished flutes for good chip clearance.**

A **slim chisel point** and the **special arrangement of the 4 guide chamfers** ensure **high positioning and alignment accuracy**. Optimised micro-geometry for increased working life and performance capability.

Note:

Flute length $L_c = L_2 + 1.5 \times D_c$.

Versions HB and HE supplied at the same price as HA.

Form **HB**: order with **No. 123026**.

Form **HE**: order with **No. 123025 + 129100HE**.

Technical description

Nominal Ø D_c	18 mm
Shank Ø D_s	18 mm
Number of cutting edges Z	2
Feed f in steel < 1100 N/mm ²	0.29 mm/rev.
Flute length L_c	171 mm
Standard	Manufacturer's standard

Overall length L	222 mm
Tolerance nominal \varnothing	h7
recommended maximum drilling depth L ₂	144 mm
Series	Master Steel
Coating	TiAlN
Tool material	Solid carbide
Version	8xD
Point angle	135 degrees
Shank	DIN 6535 HA to h6
Through-coolant	yes, with 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	195 m/min	P
Steel < 750 N/mm ²	suitable	150 m/min	P
Steel < 900 N/mm ²	suitable	135 m/min	P
Steel < 1100 N/mm ²	suitable	125 m/min	P
Steel < 1400 N/mm ²	suitable	80 m/min	P
INOX < 900 N/mm ²	suitable only under restricted conditions	65 m/min	M
GG	suitable	120 m/min	K
GGG	suitable	115 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable		

Services

Shank grinding Type HE

129100 HE