ᶃᵒ Hoffmann Group

Garant

GARANT Master Steel SPEED solid carbide drill, plain shank DIN 6535 HA, TiAlN, ⌀ DC h7: 6mm

Order data

Order number	123225 6
GTIN	4045197845092
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 $L_c = L_2 + 1.5 \times D_c$.
For process reliability when using the 12×D drill, an initial centre drilling with NC spotting drills No. 121068 – 121130 is necessary.
Form HB and HE are supplied at the same price as HA.
Order form **HB:** with **No. 123226**.
Order form **HE:** with **No. 123225 + 129100HE**.

Technical description

Tolerance nominal ⌀	h7
Feed f in steel < 1100 N/mm^2	0.125 mm/rev.
Overall length L	116 mm
Shank ⌀ D_s	6 mm
recommended maximum drilling depth L_2	69 mm

Number of cutting edges Z	2
Flute length L_c	78 mm
Standard	Manufacturer's standard
Nominal Ø D_c	6 mm
Series	Master Steel
Coating	TiAlN
Tool material	Solid carbide
Version	12×D
Point angle	135 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/mm²	suitable	160 m/min	P
Steel < 750 N/mm²	suitable	125 m/min	P
Steel < 900 N/mm²	suitable	115 m/min	P
Steel < 1100 N/mm²	suitable	105 m/min	P
Steel < 1400 N/mm²	suitable	65 m/min	P
INOX < 900 N/mm²	suitable only under restricted conditions	55 m/min	M
GG	suitable	100 m/min	K
GGG	suitable	95 m/min	K
Uni	suitable		
wet maximum	suitable		

wet minimum	suitable

Services

Shank grinding Type HE	129100 HE