

Garant

GARANT Master Steel SPEED solid carbide drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7: 7,7mm



Order data

Order number	123225 7,7
GTIN	4045197845269
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 12xD 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 Ø	h7
Number of cutting edges Z	2
Flute length L_c	108 mm
Shank Ø D_s	8 mm
Overall length L	146 mm

recommended maximum drilling depth L_2	96.5 mm
Standard	Manufacturer's standard
Feed f in steel $< 1100 \text{ N/mm}^2$	0.15 mm/rev.
Nominal $\varnothing D_c$	7.7 mm
Series	Master Steel
Coating	TiAlN
Tool material	Solid carbide
Version	12xD
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 $< 500 \text{ N/mm}^2$	suitable	160 m/min	P
Steel $< 750 \text{ N/mm}^2$	suitable	125 m/min	P
Steel $< 900 \text{ N/mm}^2$	suitable	115 m/min	P
Steel $< 1100 \text{ N/mm}^2$	suitable	105 m/min	P
Steel $< 1400 \text{ N/mm}^2$	suitable	65 m/min	P
INOX $< 900 \text{ N/mm}^2$	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
Services

suitable

Shank grinding Type HE

129100 HE