GARANT Master Steel SPEED solid carbide drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 4,7mm

Order data

Order number	123226 4,7
GTIN	4045197847409
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 deep-hole drill, an initial centre drilling with No. 121068 – 121130 or 3×D pilot drilling operation with No. 122736 is necessary.

Technical description

Shank Ø D_s	6 mm
Overall length L	102 mm
Nominal Ø D_C	4.7 mm
Flute length L_c	64 mm
Tolerance nominal Ø	h7
Feed f in steel < 1100 N/mm^2	0.1 mm/rev.
recommended maximum drilling depth L_2	57 mm

Number of cutting edges Z	2
Standard	Manufacturer’s standard
Series	Master Steel
Coating	TiAlN
Tool material	Solid carbide
Version	12×D
Point angle	135 degrees
Shank	DIN 6535 HB to h6
Through-coolant	yes, to 25 bar
Machining strategy	HPC
Pilot drill required	yes, pilot drill
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		