

## Garant

### GARANT Master Steel SPEED solid carbide drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 5,9mm



## Order data

|              |               |
|--------------|---------------|
| Order number | 123226 5,9    |
| GTIN         | 4045197847522 |
| 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 deep-hole drill, an initial centre drilling with No. 121068 – 121130 or 3xD pilot drilling operation with No. 122736 is necessary.

## Technical description

|   |                         |
|---|-------------------------|
| Shank Ø D <sub>s</sub>                            | 6 mm                    |
| Feed f in steel < 1100 N/mm <sup>2</sup>          | 0.125 mm/rev.           |
| Flute length L <sub>c</sub>                       | 78 mm                   |
| Nominal Ø D <sub>c</sub>                          | 5.9 mm                  |
| recommended maximum drilling depth L <sub>2</sub> | 69.2 mm                 |
| Standard  | Manufacturer's standard |
| Overall length L                                  | 116 mm                  |

|                                 |                   |
|---------------------------------|-------------------|
| Tolerance nominal $\varnothing$ | h7                |
| Number of cutting edges Z       | 2                 |
| Series                          | Master Steel      |
| Coating                         | TiAlN             |
| Tool material                   | Solid carbide     |
| Version                         | 12xD              |
| 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/mm <sup>2</sup>  | suitable                                  | 160 m/min | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable                                  | 125 m/min | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable                                  | 115 m/min | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable                                  | 105 m/min | P        |
| Steel < 1400 N/mm <sup>2</sup> | suitable                                  | 65 m/min  | P        |
| INOX < 900 N/mm <sup>2</sup>   | 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                                  |           |          |

