

Garant

GARANT Master Steel SPEED solid carbide drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 6,3mm



Order data

Order number	123226 6,3
GTIN	4045197847560
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

recommended maximum drilling depth L_2	98.6 mm
Feed f in steel $< 1100 \text{ N/mm}^2$	0.15 mm/rev.
Flute length L_c	108 mm
Number of cutting edges Z	2
Shank $\varnothing D_s$	8 mm
Nominal $\varnothing D_c$	6.3 mm
Overall length L	146 mm

Tolerance nominal \varnothing	h7
Standard	Manufacturer's standard
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 ²	suitable	160 m/min	P
Steel < 750 N/mm ²	suitable	125 m/min	P
Steel < 900 N/mm ²	suitable	115 m/min	P
Steel < 1100 N/mm ²	suitable	105 m/min	P
Steel < 1400 N/mm ²	suitable	65 m/min	P
INOX < 900 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	suitable		

