

Garant

GARANT Master Steel SPEED solid carbide drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 15mm



Order data

| | |
|--------------|---------------|
| Order number | 123226 15 |
| GTIN | 4045197848253 |
| 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 | 185.5 mm |
| Number of cutting edges Z | 2 |
| Tolerance nominal Ø | h7 |
| Feed f in steel < 1100 N/mm ² | 0.26 mm/rev. |
| Standard | Manufacturer's standard |
| Overall length L | 260 mm |
| Nominal Ø D_c | 15 mm |

| | |
|-------------------------|-------------------|
| Flute length L_c | 208 mm |
| Shank $\varnothing D_s$ | 16 mm |
| 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 | | |

