

Garant

GARANT Master Steel FEED solid carbide NC spotting drill, plain shank 155° DIN 6535 HA, TiAlN, Ø DC h6: 5mm



Order data

Order number	121130 5
GTIN	4045197886989
Item class	11E

Description

Version:

3-flute NC spotting drill with high positioning accuracy and special point angle 155° for the GARANT Master Steel FEED drill. The **sector-leading technology of the drill point** guarantees **optimum self-centring behaviour** and permits spot drilling on irregular surfaces.

Note:

Form HB and HE supplied at the same price as HA.

Form **HB**: order with **No. 121130 + 129100 HB**.

Form **HE**: order with **No. 121130 + 129100 HE**.

Technical description

Flute length L_c	7 mm
Shank tolerance	h6
Feed f in steel $< 1100 \text{ N/mm}^2$	0.12 mm/rev.
Nominal $\varnothing D_c$	5 mm
Shank $\varnothing D_s$	6 mm
Overall length L	62 mm
Depth of spot facing	0.3 - 0.5 mm
Shank	DIN 6535 HA to h6
Coating	TiAlN
Tool material	Solid carbide

Standard	Manufacturer's standard
Tolerance nominal \varnothing	h6
Point angle	155 degrees
Number of cutting edges Z	3
Through-coolant	no
Colour ring	without
Series	Master Steel
Type of product	Spotting drill

User data

	Suitability	V_c	ISO code
Alu plastics	suitable only under restricted conditions	260 m/min	N
Aluminium (short chipping)	suitable	220 m/min	N
Alu > 10% Si	suitable	200 m/min	N
Steel < 500 N/mm ²	suitable	120 m/min	P
Steel < 750 N/mm ²	suitable	110 m/min	P
Steel < 900 N/mm ²	suitable	100 m/min	P
Steel < 1100 N/mm ²	suitable	90 m/min	P
Steel < 1400 N/mm ²	suitable	70 m/min	P
Steel < 55 HRC	suitable	60 m/min	H
INOX < 900 N/mm ²	suitable	55 m/min	M
INOX > 900 N/mm ²	suitable	50 m/min	M
Ti > 850 N/mm ²	suitable only under restricted conditions	40 m/min	S
GG	suitable	120 m/min	K
GGG	suitable	80 m/min	K
Uni	suitable		
Oil	suitable		

wet maximum	suitable
wet minimum	suitable
dry	suitable only under restricted conditions

Services

Shank grinding Type HE	129100 HE
Shank grinding Type HB	129100 HB