

## Garant

### GARANT Master Steel SPEED solid carbide drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7: 10,06-Xmm



#### Order data

|              |                |
|--------------|----------------|
| Order number | 123225 10,06-X |
| GTIN         | 4062406080433  |
| 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 drill, an initial centre drilling with NC spotting drills No. 121068 – 121130 is necessary.

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

Order form **HB**: with **No. 123226**.

Order form **HE**: with **No. 123225 + 129100HE**. Delivery time: 12 working weeks

Minimum order quantity: 3 pcs

Items made to order for a specific customer:

Cancellation only up to a maximum of 3 working days after receipt of order acknowledgement.

Items cannot be returned. We reserve the right to over-deliver or under-deliver by  $\pm 10\%$  (minimum 1 piece).

#### Technical description

|                     |    |
|---------------------|----|
| Tolerance nominal Ø | h7 |
|---------------------|----|

|                           |                         |
|---------------------------|-------------------------|
| Number of cutting edges Z | 2                       |
| Flute length $L_c$        | 156 mm                  |
| Shank $\varnothing D_s$   | 12 mm                   |
| Overall length L          | 204 mm                  |
| Standard                  | Manufacturer's standard |
| $\varnothing$ range       | 10.06 - 12.05 mm        |
| Series                    | Master Steel            |
| Coating                   | TiAlN                   |
| Tool material             | Solid carbide           |
| Version                   | 12xD                    |
| Point angle               | 135 degrees             |
| Shank                     | DIN 6535 HA to h6       |
| Through-coolant           | yes, to 25 bar          |
| Machining strategy        | HPC                     |
| 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 |