

Garant

GARANT Master Steel SPEED solid carbide drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7: 18,06-Xmm



Order data

Order number	123225 18,06-X
GTIN	4062406080471
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

Shank Ø D _s	20 mm
------------------------	-------

Overall length L	30 mm
Tolerance nominal \varnothing	h7
Number of cutting edges Z	2
Standard	Manufacturer's standard
Flute length L_c	258 mm
\varnothing range	18.06 - 20.05 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 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