

Garant

GARANT Master Steel SPEED solid carbide drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7: 2mm



Order data

| | |
|--------------|---------------|
| Order number | 122415 2 |
| GTIN | 4045197781178 |
| Item class | 11E |

Description

Version:

Developed for use with **very high cutting speeds**. Outstandingly suitable for machines with **low power output** 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 edge** 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 $L_c = L_2 + 1.5 \times D_c$.

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

Form **HB**: order with **No. 122416**.

Form **HE**: order with **No. 122415 + 129100HE**.

Standard: DIN 6537 K

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

Tolerance nominal Ø: h7

recommended maximum drilling depth L_2 : 17 mm

Overall length L: 55 mm

Shank Ø D_s : 4 mm

Feed f in steel $< 1100 \text{ N/mm}^2$: 0.09 mm/rev.

Technical description

| | |
|---|--------------|
| Feed f in steel $< 1100 \text{ N/mm}^2$ | 0.09 mm/rev. |
|---|--------------|

| | |
|--|-------------------|
| Number of cutting edges Z | 2 |
| Standard | DIN 6537 K |
| Shank $\varnothing D_s$ | 4 mm |
| Overall length L | 55 mm |
| Shank tolerance | h6 |
| Flute length L_c | 20 mm |
| Tolerance nominal \varnothing | h7 |
| Nominal $\varnothing D_c$ | 2 mm |
| recommended maximum drilling depth L_2 | 17 mm |
| Series | Master Steel |
| Coating | TiAlN |
| Tool material | solid carbide |
| Version | 4xD |
| Point angle | 135 ° |
| Shank | DIN 6535 HA to h6 |
| Through-coolant | no |
| 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 | 170 m/min | P |
| Steel < 750 N/mm ² | suitable | 150 m/min | P |
| Steel < 900 N/mm ² | suitable | 120 m/min | P |
| Steel < 1100 N/mm ² | suitable | 110 m/min | P |
| Steel < 1400 N/mm ² | suitable only under restricted conditions | 60 m/min | P |

| | | | |
|-------------|----------|-----------|---|
| GG | suitable | 110 m/min | K |
| GGG | suitable | 100 m/min | K |
| Uni | suitable | | |
| wet maximum | suitable | | |