Garant

GARANT Master Steel solid carbide high-performance drill DIN 6535 HA, TiAlN, ⌀ DC h7: 13,8mm

Order data

Order number	122761 13,8
GTIN	4067263121893
Item class	11E

Description

Version:
Robust drill design and optimised special point geometry for the **best possible chip formation and reliable chip breakage** with **higher feed rates at the same time. Advanced micro-geometry, convex** cutting edge and **relieved cone**to provide additional stability for the main cutting edge. **Optimised flute geometry and patented face geometry** for **reliable chip evacuation** in steel materials and cast material. **High-performance coating** of the latest generation.
Note:
Flute length $L_C = L_2 + 1.5 \times D_C$.
HB and HE shanks are available at the same price as HA.
HB shanks: order with **No. 122762**.
For **HE shanks:** use order **No. 122761 + 129100HE**.

Technical description

Number of cutting edges Z	2
Standard	DIN 6537
Shank ⌀ D_s	14 mm
Flute length L_c	77 mm
Overall length L	124 mm
recommended maximum drilling depth L_2	56.3 mm
Tolerance nominal ⌀	h7

Nominal Ø D_C	13.8 mm
Feed f in steel < 1100 N/mm²	0.37 mm/rev.
Series	Master Steel
Coating	TiAlN
Tool material	Solid carbide
Version	6×D
Point angle	140 degrees
Shank	DIN 6535 HA to h6
Through-coolant	yes, with 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/mm²	suitable	170 m/min	P
Steel < 750 N/mm²	suitable	155 m/min	P
Steel < 900 N/mm²	suitable	145 m/min	P
Steel < 1100 N/mm²	suitable	130 m/min	P
Steel < 1400 N/mm²	suitable	110 m/min	P
Steel < 55 HRC	suitable	60 m/min	H
INOX < 900 N/mm²	suitable only under restricted conditions	55 m/min	M
INOX > 900 N/mm²	suitable only under restricted conditions	45 m/min	M
GG	suitable	130 m/min	K
GGG	suitable	90 m/min	K
Uni	suitable		

wet maximum	suitable
wet minimum	suitable
Air	suitable