

Garant
GARANT Master Steel solid carbide high-performance drill DIN 6535 HA, TiAlN, Ø DC h7: 18mm

Order data

Order number	122761 18
GTIN	4067263122029
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 coneto** 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

Flute length L_c	93 mm
Overall length L	143 mm
Shank Ø D_s	18 mm
Feed f in steel $< 1100 \text{ N/mm}^2$	0.42 mm/rev.
Standard	DIN 6537
Tolerance nominal Ø	h7
Nominal Ø D_c	18 mm

recommended maximum drilling depth L_2	66 mm
Number of cutting edges Z	2
Series	Master Steel
Coating	TiAlN
Tool material	Solid carbide
Version	6xD
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/mm ²	suitable	170 m/min	P
Steel < 750 N/mm ²	suitable	155 m/min	P
Steel < 900 N/mm ²	suitable	145 m/min	P
Steel < 1100 N/mm ²	suitable	130 m/min	P
Steel < 1400 N/mm ²	suitable	110 m/min	P
Steel < 55 HRC	suitable	60 m/min	H
INOX < 900 N/mm ²	suitable only under restricted conditions	55 m/min	M
INOX > 900 N/mm ²	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