

Garant

GARANT Master Steel DEEP solid carbide pilot drill, plain shank DIN 6535 HA 6xD, TiAlN, Ø DC: 3mm



Order data

| | |
|--------------|---------------|
| Order number | 123885 3 |
| GTIN | 4062406266264 |
| Item class | 11E |

Description

Version:

Excellent chip evacuation due to the unequal helical pitch of the flutes, guide rings and additional guide chamfers for very high precision when drilling. **Maximum process reliability** due to exactly matching tools within the overall system. Drilling up to the maximum depth without a pilot drill. **Significantly increased tool stability** due to the substantially strengthened core. **Increased metal removal rates** and **outstanding tool lives** lead to an economical high-end drilling process.

Strong core and special point geometry for high centring accuracy. 140° tip angle and special p6 cutting tolerance for optimum generation of a pilot hole for subsequent use of the GARANT Master Steel deep hole drill.

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. 123886**.

Form **HE**: order with **No. 123885 + 129100HE**.

Technical description

| | |
|---------------------------------|-------|
| Flute length L_c | 28 mm |
| Overall length L | 66 mm |
| Number of cutting edges Z | 2 |
| Tolerance nominal \varnothing | p6 |
| Shank $\varnothing D_s$ | 6 mm |

| | |
|---|-------------------------|
| recommended maximum drilling depth L_2 | 23.5 mm |
| Nominal $\varnothing D_c$ | 3 mm |
| Standard | Manufacturer's standard |
| Feed f in steel < 900 N/mm ² | 0.08 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 40 bar |
| Machining strategy | HPC |
| 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 | 130 m/min | P |
| Steel < 1100 N/mm ² | suitable | 110 m/min | P |
| Steel < 1400 N/mm ² | suitable | 90 m/min | P |
| INOX < 900 N/mm ² | suitable | 75 m/min | M |
| INOX > 900 N/mm ² | suitable | 70 m/min | M |
| Ti > 850 N/mm ² | suitable only under restricted conditions | 35 m/min | S |
| GG(G) | suitable | 120 m/min | K |
| Uni | suitable | | |
| wet maximum | suitable | | |

wet minimum

suitable only under
restricted conditions