ᚿᛟ Hoffmann Group

Garant

GARANT Master Steel DEEP solid carbide pilot drill, plain shank DIN 6535 HA 6×D, TiAlN, Ø DC: 4,2mm

Order data

Order number	123885 4,2
GTIN	4062406267278
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

Number of cutting edges Z	2
Standard	Manufacturer's standard
Overall length L	74 mm
Shank Ø D_s	6 mm
Feed f in steel < 900 N/mm^2	0.15 mm/rev.

Nominal Ø D_c	4.2 mm
Tolerance nominal Ø	p6
recommended maximum drilling depth L_2	29.7 mm
Flute length L_c	36 mm
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/mm²	suitable	170 m/min	P
Steel < 750 N/mm²	suitable	150 m/min	P
Steel < 900 N/mm²	suitable	130 m/min	P
Steel < 1100 N/mm²	suitable	110 m/min	P
Steel < 1400 N/mm²	suitable	90 m/min	P
INOX < 900 N/mm²	suitable	75 m/min	M
INOX > 900 N/mm²	suitable	70 m/min	M
Ti > 850 N/mm²	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