

Garant
GARANT Master Steel DEEP solid carbide pilot drill, plain shank DIN 6535 HA 6xD, TiAlN, Ø DC: 8mm

Order data

Order number	123885 8
GTIN	4062406267438
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
Tolerance nominal Ø	p6
Overall length L	91 mm
Nominal Ø D_c	8 mm
Standard	Manufacturer's standard

recommended maximum drilling depth L_2	41 mm
Flute length L_c	53 mm
Feed f in steel $< 900 \text{ N/mm}^2$	0.21 mm/rev.
Shank $\varnothing D_s$	8 mm
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 40 bar
Machining strategy	HPC
Colour ring	green
Type of product	Jobber drill

User data

	Suitability	V_c	ISO code
Steel $< 500 \text{ N/mm}^2$	suitable	170 m/min	P
Steel $< 750 \text{ N/mm}^2$	suitable	150 m/min	P
Steel $< 900 \text{ N/mm}^2$	suitable	130 m/min	P
Steel $< 1100 \text{ N/mm}^2$	suitable	110 m/min	P
Steel $< 1400 \text{ N/mm}^2$	suitable	90 m/min	P
INOX $< 900 \text{ N/mm}^2$	suitable	75 m/min	M
INOX $> 900 \text{ N/mm}^2$	suitable	70 m/min	M
Ti $> 850 \text{ N/mm}^2$	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