

**Garant**
**GARANT Master Steel DEEP solid carbide pilot drill, plain shank DIN 6535 HA 6xD, TiAlN, Ø DC: 8,5mm**

**Order data**

Order number	123885 8,5
GTIN	4062406267445
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**

Shank Ø D <sub>s</sub>	10 mm
Tolerance nominal Ø	p6
recommended maximum drilling depth L <sub>2</sub>	48.3 mm
Nominal Ø D <sub>c</sub>	8.5 mm
Feed f in steel < 900 N/mm <sup>2</sup>	0.24 mm/rev.

Number of cutting edges Z	2
Flute length $L_c$	61 mm
Overall length L	103 mm
Standard	Manufacturer's standard
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 N/mm <sup>2</sup>	suitable	170 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	150 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	130 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	110 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	90 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	75 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	70 m/min	M
Ti > 850 N/mm <sup>2</sup>	suitable only under restricted conditions	35 m/min	S
GG(G)	suitable	120 m/min	K
Uni	suitable		
wet maximum	suitable		

wet minimum

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restricted conditions