Garant

GARANT Master Steel DEEP solid carbide deep hole drill, plain shank DIN 6535 HA 16×D, TiAlN, Ø DC: 6,8mm

Order data

Order number	123888 6,8
GTIN	4062406267780
Item class	10E

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.
Note:
For process reliability when using the 16×D deep-hole drill, initial centre drilling with No. 121068 – 121121 or a pilot hole of at least 4×D with pilot drill No. 122736 is necessary. For deep holes greater than 20×D, a pilot hole to the maximum drilling depth with pilot drill No. 122736 is absolutely essential. The generation of a pilot hole improves process reliability. **The specified L/D ratio gives the minimum achievable depth of hole with the respective deep-hole drill.**
Flute length $L_C = L_2 + 1.5 \times D_C$.

Technical description

Shank Ø D_s	8 mm
Nominal Ø D_C	6.8 mm
Tolerance nominal Ø	j6
recommended maximum drilling depth L_2	119.8 mm
Number of cutting edges Z	2
Flute length L_c	130 mm

Feed f in steel < 900 N/mm²	0.16 mm/rev.
Overall length L	172 mm
Standard	Manufacturer's standard
Series	Master Steel
Coating	TiAlN
Tool material	Solid carbide
Version	16×D
Point angle	138 degrees
Shank	DIN 6535 HA to h6
Through-coolant	yes, with 40 bar
Machining strategy	HPC
Pilot drill required	yes, pilot drill
Colour ring	green
Type of product	Jobber drill

User data

	Suitability	V_c	ISO code
Steel < 500 N/mm²	suitable only under restricted conditions	125 m/min	P
Steel < 750 N/mm²	suitable	115 m/min	P
Steel < 900 N/mm²	suitable only under restricted conditions	110 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	65 m/min	M
INOX > 900 N/mm²	suitable only under restricted conditions	60 m/min	M
Ti > 850 N/mm²	suitable only under restricted conditions	30 m/min	S

GG(G)	suitable only under restricted conditions	115 m/min	K
Uni	suitable		
wet maximum	suitable only under restricted conditions		
wet minimum	suitable only under restricted conditions		