

## Garant

### GARANT Master Steel DEEP solid carbide deep hole drill, plain shank DIN 6535 HA 25×D, TiAlN, Ø DC j6: 8,5mm



#### Order data

Order number	123893 8,5
GTIN	4062406268619
Item class	10E

#### Description

##### Version:

**Excellent chip evacuation** due to the unequal helical pitch of the flutes, guide rings and additional flute lands 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:

Flute length  $L_c = L_2 + 1.5 \times D_c$ . For deep holes greater than  $20 \times D$ , a pilot hole to the maximum drilling depth with pilot drill No. 123885 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.**

#### Technical description

Standard	Manufacturer's standard
Shank $\varnothing D_s$	10 mm
Tolerance nominal $\varnothing$	j6
Overall length L	280 mm
Number of cutting edges Z	2
recommended maximum drilling depth $L_2$	221.25 mm
Flute length $L_c$	234 mm
Nominal $\varnothing D_c$	8.5 mm

Feed f in steel < 900 N/mm <sup>2</sup>	0.19 mm/rev.
Series	Master Steel
Coating	TiAlN
Tool material	Solid carbide
Version	25xD
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 <sub>c</sub>	ISO code
Steel < 500 N/mm <sup>2</sup>	suitable	110 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	100 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	95 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable only under restricted conditions	95 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	75 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	60 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable only under restricted conditions	55 m/min	M
GG(G)	suitable	100 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		

