Garant

GARANT Master Steel DEEP solid carbide pilot drill, plain shank DIN 6535 HB 6×D, TiAlN, Ø DC: 4,5mm

Order data

Order number	123886 4,5
GTIN	4062406300111
Item class	11E

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.
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 $L_c = L_2 + 1.5 \times D_C$.

Technical description

Tolerance nominal Ø	p6
Shank Ø D_s	6 mm
Flute length L_c	36 mm
Standard	Manufacturer's standard
Overall length L	74 mm
Nominal Ø D_C	4.5 mm
Number of cutting edges Z	2

Feed f in steel < 900 N/mm^2	0.15 mm/rev.
recommended maximum drilling depth L$_2$	30.3 mm
Series	Master Steel
Coating	TiAlN
Tool material	Solid carbide
Version	6×D
Point angle	140 degrees
Shank	DIN 6535 HB to h5
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^2	suitable	170 m/min	P
Steel < 750 N/mm^2	suitable	150 m/min	P
Steel < 900 N/mm^2	suitable	130 m/min	P
Steel < 1100 N/mm^2	suitable	110 m/min	P
Steel < 1400 N/mm^2	suitable	90 m/min	P
INOX < 900 N/mm^2	suitable	75 m/min	M
INOX > 900 N/mm^2	suitable	70 m/min	M
Ti > 850 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		