

**Garant**
**GARANT Master Steel DEEP solid carbide pilot drill, plain shank DIN 6535 HB 6xD, TiAlN, Ø DC: 13mm**

**Order data**

Order number	123886 13
GTIN	4062406300258
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**

recommended maximum drilling depth $L_2$	57.5 mm
Nominal $\varnothing D_c$	13 mm
Shank $\varnothing D_s$	14 mm
Flute length $L_c$	77 mm
Standard	Manufacturer's standard
Overall length L	124 mm
Feed f in steel < 900 N/mm <sup>2</sup>	0.29 mm/rev.

Tolerance nominal $\varnothing$	p6
Number of cutting edges Z	2
Series	Master Steel
Coating	TiAlN
Tool material	Solid carbide
Version	6xD
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 <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	suitable only under restricted conditions		

