

Garant

GARANT Master Steel MICRO solid carbide drill, plain shank DIN 6535 HA 20xD, AlCrN, Ø DC h6: 0,85mm



Order data

| | |
|--------------|---------------|
| Order number | 121228 0,85 |
| GTIN | 4062406580865 |
| Item class | 10F |

Description

Version:

High-performance micro-drill for universal material use, focussing on steel processing. Maximum process reliability due to **exactly matched tools within the overall system** and **expanded guide chamfer**. Drilling of very small diameters down to the maximum depth after creating a pilot hole. **Optimum compromise between core diameter and flute size for optimum chip evacuation** – even with long-chipping materials. The **increased metal removal rates and longer tool life** ensure an economical drilling process, even with very small hole diameters combined with a large L/D ratio.

Note:

For reliable use of the micro-drills from 8xD, a **pilot hole of at least 4xD** is required using the micro-pilot drill 121223. For vertical machining and flat workpiece surfaces, a pilot hole can be dispensed with from $D_c = \varnothing 1 \text{ mm}$ up to a length of 12xD. Please always ensure that the **pilot hole is free from chips** before using the subsequent drilling tool. We recommend setting a 90° counterbore with a suitable NC spotting drill after the pilot hole has been completed. For critical applications (e.g. highest possible production accuracy, minimal burr formation, reduced coolant pressure), reduce the feed rate of the tool by 50% before entering and exiting the material. Long-chipping materials may require **chips to be evacuated** in steps of 3xD each by moving the drill back slightly at pilot hole depth. Please make sure that you use a suitable **tool clamping device** (shrink-fit chuck, hydraulic clamping chuck) with a radial run-out of less than 0.003 mm, a sufficiently high **coolant pressure** (at least 30 bar), as well as sufficiently fine **filtration** of the cooling medium ($D_c < \varnothing 2 \text{ mm}$ with filter $\leq 0.010 \text{ mm}$; $D_c < \varnothing 3 \text{ mm}$ filter $\leq 0.020 \text{ mm}$). The specified L/D ratio gives the **minimum achievable depth of hole** with the respective micro-drill. Flute length $L_c = L_2 + 1.5 \times D_c$.

Technical description

| | |
|---|-------------------------|
| Nominal $\varnothing D_c$ | 0.85 mm |
| Tolerance nominal \varnothing | h6 |
| Shank $\varnothing D_s$ | 3 mm |
| Flute length L_c | 19.8 mm |
| Number of cutting edges Z | 2 |
| Feed f in steel < 1100 N/mm ² | 0.028 mm/rev. |
| Overall length L | 53 mm |
| Standard | Manufacturer's standard |
| Feed f in stainless steel < 900 N/mm ² | 0.015 mm/rev. |
| recommended maximum drilling depth L_2 | 18.5 mm |
| Series | Master Steel |
| Coating | AlCrN |
| Tool material | Solid carbide |
| Version | 20xD |
| Point angle | 128 degrees |
| Shank | DIN 6535 HA to h6 |
| Through-coolant | yes, with 25 bar |
| Machining strategy | HPC |
| Pilot drill required | yes, pilot drill |
| Semi-Standard | yes |
| Colour ring | green |
| Type of product | Jobber drill |

User data

| | Suitability | V_c | ISO code |
|----------------------------|---|----------|----------|
| Aluminium (short chipping) | suitable only under restricted conditions | 50 m/min | N |
| Alu > 10% Si | suitable only under restricted conditions | 50 m/min | N |

| | | | |
|--------------------------------|--|----------|---|
| Steel < 750 N/mm ² | suitable | 70 m/min | P |
| Steel < 900 N/mm ² | suitable | 60 m/min | P |
| Steel < 1100 N/mm ² | suitable | 50 m/min | P |
| Steel < 1400 N/mm ² | Suitable | 42 m/min | P |
| INOX < 900 N/mm ² | suitable | 42 m/min | M |
| INOX > 900 N/mm ² | suitable | 30 m/min | M |
| Ti > 850 N/mm ² | suitable only under restricted conditions | 25 m/min | S |
| GG(G) | suitable | 58 m/min | K |
| CuZn | suitable only under restricted conditions | 50 m/min | N |
| Uni | suitable | | |
| wet maximum | suitable | | |