GARANT Master Steel DEEP solid carbide deep hole drill, plain shank DIN 6535 HA 25×D, TiAlN, Ø DC j6: 6,5mm

Order data

Order number	123893 6,5
GTIN	4067263123071
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×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

Shank Ø D_s	8 mm
Overall length L	221 mm
Flute length L_c	179.05 mm
Standard	Works standard
Nominal Ø D_C	6.5 mm
recommended maximum drilling depth L_2	169.3 mm
Feed f in steel < 900 N/mm^2	0.16 mm/rev.
Number of cutting edges Z	2

Tolerance nominal ⌀	j6
Series	Master Steel
Coating	TiAlN
Tool material	Solid carbide
Version	25×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	110 m/min	P
Steel < 750 N/mm²	suitable	100 m/min	P
Steel < 900 N/mm²	suitable	95 m/min	P
Steel < 1100 N/mm²	suitable only under restricted conditions	95 m/min	P
Steel < 1400 N/mm²	suitable	75 m/min	P
INOX < 900 N/mm²	suitable	60 m/min	M
INOX > 900 N/mm²	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		