

## Garant

### GARANT Master Steel DEEP solid carbide deep hole drill, plain shank DIN 6535 HA 30×D, TiAlN, Ø DC j6: 3,2mm



#### Order data

|              |               |
|--------------|---------------|
| Order number | 123895 3,2    |
| GTIN         | 4067263123163 |
| 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

|  |                |
|--|----------------|
| Feed f in steel < 900 N/mm <sup>2</sup>  | 0.07 mm/rev.   |
| recommended maximum drilling depth $L_2$ | 99.2 mm        |
| Shank Ø $D_s$                            | 6 mm           |
| Nominal Ø $D_c$                          | 3.2 mm         |
| Standard                                 | Works standard |
| Flute length $L_c$                       | 104 mm         |
| Number of cutting edges Z                | 2              |
| Tolerance nominal Ø                      | j6             |

|                      |                   |
|----------------------|-------------------|
| Overall length L     | 147 mm            |
| Series               | Master Steel      |
| Coating              | TiAlN             |
| Tool material        | Solid carbide     |
| Version              | 30xD              |
| 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                                  | 105 m/min      | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable                                  | 95 m/min       | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable                                  | 85 m/min       | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable                                  | 85 m/min       | P        |
| Steel < 1400 N/mm <sup>2</sup> | suitable                                  | 70 m/min       | P        |
| INOX < 900 N/mm <sup>2</sup>   | suitable                                  | 55 m/min       | M        |
| INOX > 900 N/mm <sup>2</sup>   | suitable only under restricted conditions | 50 m/min       | M        |
| GG(G)                          | suitable                                  | 95 m/min       | K        |
| Uni                            | suitable                                  |                |          |
| wet maximum                    | suitable                                  |                |          |
| wet minimum                    | suitable only under restricted conditions |                |          |

