

Garant
GARANT Master Steel DEEP solid carbide deep hole drill, plain shank DIN 6535 HA 30×D, TiAlN, Ø DC j6: 4,2mm

Order data

| | |
|--------------|---------------|
| Order number | 123895 4,2 |
| GTIN | 4067263123187 |
| 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

| Standard | Works standard |
|---|----------------|
| Number of cutting edges Z | 2 |
| Feed f in steel < 900 N/mm ² | 0.11 mm/rev. |
| recommended maximum drilling depth L ₂ | 140.7 mm |
| Flute length L _c | 147 mm |
| Nominal Ø D _c | 4.2 mm |
| Tolerance nominal Ø | j6 |
| Shank Ø D _s | 6 mm |

| | |
|----------------------|-------------------|
| Overall length L | 189 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 _c | ISO code |
|--------------------------------|---|----------------|----------|
| Steel < 500 N/mm ² | suitable | 105 m/min | P |
| Steel < 750 N/mm ² | suitable | 95 m/min | P |
| Steel < 900 N/mm ² | suitable | 85 m/min | P |
| Steel < 1100 N/mm ² | suitable | 85 m/min | P |
| Steel < 1400 N/mm ² | suitable | 70 m/min | P |
| INOX < 900 N/mm ² | suitable | 55 m/min | M |
| INOX > 900 N/mm ² | 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 | | |

