

**Garant**
**Carbide single-lip drill Overall length L 1000 mm, TiAlN, Ø: 19,8-Xmm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 124010 19,8-X |
| GTIN         | 4067263329558 |
| Item class   | 10D           |

**Description**
**Version:**

Single-edged straight flute deep-hole drill for drilling depths of up to 1000 mm as standard and up to 6000 mm on request. Universally designed circumferential shape of the drilling head enables reliable working in a wide range of materials.

**Note:**

For the reliable use of deep hole drills, a pilot hole of at least  $4 \times D$  with pilot drill No. 122736 or No. 123885 and 231605 for larger diameters, or with pilot drill No. 122606 for aluminium, is required. For deep holes  $> 50 \times D$ , the tool must be supported with a rest at intervals of  $50 \times D$ . The specified L/D ratio gives the minimum achievable depth of hole with the respective deep-hole drill. Flute length  $L_c = L_2 + 1.5 \times D_c$ . A coolant pressure of  $> 40$  bar is recommended.

**Technical description**

|  |                 |
|--|-----------------|
| Shank Ø $D_s$                            | 32 mm           |
| Nominal Ø $D_c$                          | 19.8 mm         |
| Standard                                 | Works standard  |
| Ø range                                  | 19.8 - 20.99 mm |
| Overall length L                         | 1000 mm         |
| Number of cutting edges Z                | 1               |
| recommended maximum drilling depth $L_2$ | 898 mm          |
| Coating                                  | TiAlN           |
| Tool material                            | Carbide         |
| Shank                                    | DIN 6535 HB     |

|                      |                       |
|----------------------|-----------------------|
| Through-coolant      | yes, with min. 40 bar |
| Pilot drill required | yes, pilot drill      |
| Semi-Standard        | yes                   |

## User data

|                                | Suitability | V <sub>c</sub> | ISO code |
|--------------------------------|-------------|----------------|----------|
| Alu plastics                   | suitable    | 250 m/min      | N        |
| Aluminium (short chipping)     | suitable    | 200 m/min      | N        |
| Steel < 500 N/mm <sup>2</sup>  | suitable    | 90 m/min       | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable    | 80 m/min       | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable    | 70 m/min       | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable    | 50 m/min       | P        |
| GG                             | suitable    | 80 m/min       | K        |
| Oil                            | suitable    |                |          |
| wet maximum                    | suitable    |                |          |