

**Garant**
**Carbide single-lip drill Overall length L 1000 mm, TiAlN, Ø: 18-Xmm**

**Order data**

Order number	124010 18-X
GTIN	4067263329534
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 $D_s$	25 mm
Ø range	18 - 18.99 mm
Overall length L	1000 mm
Standard	Works standard
recommended maximum drilling depth $L_2$	905 mm
Number of cutting edges Z	1
Nominal Ø $D_C$	18 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		