

Garant
Carbide single-lip drill Overall length L 400 mm, AlTiN, Ø: 19-Xmm

Order data

Order number	124004 19-X
GTIN	4067263515050
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. 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

recommended maximum drilling depth L_2	305 mm
Nominal $\varnothing D_c$	19 mm
Shank $\varnothing D_s$	25 mm
\varnothing range	19 - 19.79 mm
Number of cutting edges Z	1
Overall length L	400 mm
Standard	Works standard
Coating	AlTiN
Tool material	Carbide
Point angle	125 degrees

Shank	DIN 6535 HB
Through-coolant	yes, with min. 40 bar
Pilot drill required	yes, pilot drill
Semi-Standard	yes

User data

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