

Garant

GARANT Master Steel MICRO solid carbide pilot drill, plain shank DIN 6535 HA 5×D, AlCrN, Ø DC: 0,85 mm



Order data

Order number	121223 0,85
GTIN	4062406579814
Item class	10F

Description

Version:

High-performance micro-drill for general-purpose use on material, focussing on steel processing. Maximum process reliability due to **exactly matched tools within the overall system** and **expanded guide chamfer**. Drilling of very small diameters down to the maximum depth after creating a pilot hole. **Optimum compromise between core diameter and flute size for optimum chip evacuation** – even with long-chipping materials. The **increased metal removal rates and longer tool life** ensure an economical drilling process, even with very small hole diameters combined with a large L/D ratio.

Note:

For reliable use of the micro-drills from 8×D, a **pilot hole of at least 4×D** is required using the micro-pilot drill 121223. For vertical machining and flat workpiece surfaces, a pilot hole can be dispensed with from $D_c = \varnothing 1$ mm up to a length of 12×D. Please always ensure that the **pilot hole is free from chips** before using the subsequent drilling tool. We recommend setting a 90° counterbore with a suitable NC spotting drill after the pilot hole has been completed. For **through holes**, reduce the feed rate of the tool by 50% before exiting the hole. Long-chipping materials may require **chips to be evacuated** in steps of 3×D each by moving the drill back slightly at pilot hole depth. Please make sure that you use a suitable **tool clamping device** (shrink-fit chuck, hydraulic clamping chuck) with a radial run-out of less than 0.003 mm, a sufficiently high **coolant pressure** (at least 30 bar), as well as sufficiently fine **filtration** of the cooling medium ($D_c < \varnothing 2$ mm with filter ≤ 0.010 mm; $D_c < \varnothing 3$ mm filter ≤ 0.020 mm). The specified L/D ratio gives the **minimum achievable depth of hole** with the respective micro-drill. Flute length $L_c = L_2 + 1.5 \times D_c$.

Standard: Manufacturer's standard

Tolerance nominal \varnothing : m6

Number of cutting edges Z: 2

Tolerance nominal \varnothing : m6

recommended maximum drilling depth L_2 : 5 mm

Overall length L: 39 mm

Shank $\varnothing D_s$: 3 mm

Feed f in steel < 1100 N/mm²: 0.028 mm/rev.

Feed f in stainless steel < 900 N/mm²: 0.015 mm/rev.

Technical description

Tolerance nominal \varnothing	m6
Nominal $\varnothing D_c$	0.85 mm
Shank $\varnothing D_s$	3 mm
Feed f in stainless steel < 900 N/mm ²	0.015 mm/rev.
Standard	Manufacturer's standard
recommended maximum drilling depth L ₂	5 mm
Overall length L	39 mm
Flute length L _c	6.3 mm
Number of cutting edges Z	2
Feed f in steel < 1100 N/mm ²	0.028 mm/rev.
Series	GARANT Master Steel
Coating	AlCrN
Tool material	Solid carbide
Drill depth up to	5×D
Point angle	135 degrees
Shank	Parallel shank to h6
Through-coolant	yes, with 40 bar
Machining strategy	HPC
Semi-Standard	yes
Colour ring	green
Type of product	Jobber drill