

Garant
GARANT Master Steel DEEP solid carbide pilot drill, plain shank DIN 6535 HA 6xD, TiAlN, Ø DC: 13 mm

Order data

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| Order number | 123885 13 |
| GTIN | 4062406267575 |
| Item class | 11E |

Description
Version:

Excellent chip evacuation due to the unequal helical pitch of the flutes, guide rings and additional guide chamfers 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.

Strong core and special point geometry for high centring accuracy. 140° tip angle and special p6 cutting tolerance for optimum generation of a pilot hole for subsequent use of the GARANT Master Steel deep hole drill.

Recommendation:
Maximum drilling depth:

flute length (see table) less 1.5×nominal Ø.

Note:

Flute length $L_c = L_2 + 1.5 \times D_c$.

Form HB and HE supplied at the same price as HA.

Form **HB**: order with **No. 123886**.

Form **HE**: order with **No. 123885 + 129100HE**.

Standard: Manufacturer's standard

Tolerance nominal Ø: p6

Number of cutting edges Z: 2

Tolerance nominal Ø: p6

Overall length L: 124 mm

Shank Ø D_s: 14 mm

Feed f in steel < 900 N/mm²: 0.29 mm/rev.

Technical description

| | |
|---|-------------------------|
| Tolerance nominal \varnothing | p6 |
| Nominal $\varnothing D_c$ | 13 mm |
| Shank $\varnothing D_s$ | 14 mm |
| Number of cutting edges Z | 2 |
| Flute length L_c | 77 mm |
| Feed f in steel < 900 N/mm ² | 0.29 mm/rev. |
| Overall length L | 124 mm |
| Standard | Manufacturer's standard |
| Series | GARANT Master Steel |
| Coating | TiAlN |
| Tool material | Solid carbide |
| Drill depth up to | 16xD |
| Point angle | 138 degrees |
| Shank | DIN 6535 HA to h5 |
| Through-coolant | yes, with 40 bar |
| Machining strategy | HPC |
| Pilot drill required | yes, pilot drill |
| Type of product | Jobber drill |