

**Garant**
**GARANT Master Steel DEEP solid carbide pilot drill, plain shank DIN 6535 HA 6xD, TiAlN, Ø DC: 6,8 mm**

**Order data**

Order number	123885 6,8
GTIN	4062406267391
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**.

Machining strategy: HPC

Standard: Manufacturer's standard

Tolerance nominal Ø: p6

Number of cutting edges Z: 2

Tolerance nominal Ø: p6

recommended maximum drilling depth  $L_2$ : 42.8 mm

Overall length L: 91 mm

Shank Ø  $D_s$ : 8 mm

Feed f in steel < 900 N/mm<sup>2</sup>: 0.21 mm/rev.

## Technical description

recommended maximum drilling depth $L_2$	42.8 mm
Shank $\varnothing D_s$	8 mm
Feed $f$ in steel $< 900 \text{ N/mm}^2$	0.21 mm/rev.
Standard	Manufacturer's standard
Nominal $\varnothing D_c$	6.8 mm
Tolerance nominal $\varnothing$	p6
Flute length $L_c$	53 mm
Overall length $L$	91 mm
Number of cutting edges $Z$	2
Series	GARANT Master Steel
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	6xD
Point angle	138 degrees
Shank	DIN 6535 HA to h5
Through-coolant	yes, with 40 bar
Machining strategy	HPC
Type of product	Jobber drill