

Garant
GARANT Master Steel DEEP solid carbide pilot drill, plain shank DIN 6535 HA 6xD, TiAlN, Ø DC: 8,5 mm

Order data

Order number	123885 8,5
GTIN	4062406267445
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: 103 mm

Shank Ø D_s : 10 mm

Feed f in steel < 900 N/mm²: 0.24 mm/rev.

Technical description

Shank Ø D _s	10 mm
Tolerance nominal Ø	p6
Nominal Ø D _c	8.5 mm
Feed f in steel < 900 N/mm ²	0.24 mm/rev.
Number of cutting edges Z	2
Flute length L _c	61 mm
Overall length L	103 mm
Standard	Manufacturer's standard
Series	GARANT Master Steel
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	16×D
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