

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

Order number	123886 6,8
GTIN	4062406300166
Item class	11E

Description**Version:**

Excellent chip evacuation due to the unequal helical pitch of the flutes, guide rings and additional flute lands 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 $L_c = L_2 + 1.5 \times D_c$.

Machining strategy: HPC

Standard: Manufacturer's standard

Tolerance nominal Ø: p6

Number of cutting edges Z: 2

Tolerance nominal Ø: p6

Overall length L: 91 mm

Shank Ø D_s : 8 mm

Feed f in steel < 900 N/mm²: 0.21 mm/rev.

Technical description

Shank Ø D _s	8 mm
Standard	Manufacturer's standard
Nominal Ø D _c	6.8 mm
Tolerance nominal Ø	p6
Overall length L	91 mm
Feed f in steel < 900 N/mm ²	0.21 mm/rev.
Flute length L _c	53 mm
Number of cutting edges Z	2
Series	GARANT Master Steel
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	16×D
Point angle	140 degrees
Shank	DIN 6535 HB to h5
Through-coolant	yes, with 40 bar
Machining strategy	HPC
Type of product	Jobber drill