

**Garant****GARANT Master Steel DEEP solid carbide pilot drill, plain shank DIN 6535 HB 6xD, TiAlN, Ø DC: 7 mm****Order data**

|              |               |
|--------------|---------------|
| Order number | 123886 7      |
| GTIN         | 4062406300173 |
| 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<sub>s</sub>: 8 mm

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

**Technical description**

|                                          |                         |
|------------------------------------------|-------------------------|
| Flute length $L_c$                       | 53 mm                   |
| Overall length $L$                       | 91 mm                   |
| Feed $f$ in steel $< 900 \text{ N/mm}^2$ | 0.21 mm/rev.            |
| Shank $\varnothing D_s$                  | 8 mm                    |
| Number of cutting edges $Z$              | 2                       |
| Standard                                 | Manufacturer's standard |
| Nominal $\varnothing D_c$                | 7 mm                    |
| Tolerance nominal $\varnothing$          | p6                      |
| Series                                   | GARANT Master Steel     |
| Coating                                  | TiAlN                   |
| Tool material                            | Solid carbide           |
| Drill depth up to                        | 16xD                    |
| Point angle                              | 140 degrees             |
| Shank                                    | DIN 6535 HB to h5       |
| Through-coolant                          | yes, with 40 bar        |
| Machining strategy                       | HPC                     |
| Type of product                          | Jobber drill            |