

Garant
GARANT Master Steel DEEP solid carbide deep-hole drill, plain shank DIN 6535 HA 16×D, TiAlN, Ø DC: 4,3 mm

Order data

Order number	123888 4,3
GTIN	4062406267674
Item class	10E

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.

Recommendation:
Maximum drilling depth:

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

Note:

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

For process reliability when using the 16×D deep-hole drill, an initial centre drilling with No. 121068 – 121130 or at least 4×D pilot drilling operation with pilot drill No. 123885 is necessary. For deep holes greater than 20×D, a pilot hole to the maximum drilling depth with pilot drill No. 123885 is absolutely essential. The generation of a pilot hole improves process reliability. **The specified L/D ratio gives the minimum achievable depth of hole with the respective deep-hole drill.**

Standard: Manufacturer's standard

Tolerance nominal Ø: j6

Number of cutting edges Z: 2

Tolerance nominal Ø: j6

recommended maximum drilling depth L_2 : 77.6 mm

Overall length L: 126 mm

Shank Ø D_s : 6 mm

Feed f in steel < 900 N/mm²: 0.11 mm/rev.

Technical description

Nominal $\varnothing D_c$	4.3 mm
Flute length L_c	84 mm
Feed f in steel $< 900 \text{ N/mm}^2$	0.11 mm/rev.
Shank $\varnothing D_s$	6 mm
Overall length L	126 mm
recommended maximum drilling depth L_2	77.6 mm
Number of cutting edges Z	2
Standard	Manufacturer's standard
Tolerance nominal \varnothing	j6
Series	GARANT Master Steel
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	16xD
Point angle	140 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