

Garant

GARANT Master Steel DEEP solid carbide deep-hole drill, plain shank DIN 6535 HA 20×D, TiAlN, Ø DC: 14 mm



Order data

| | |
|--------------|---------------|
| Order number | 123890 14 |
| GTIN | 4062406268367 |
| 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:

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 hole 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.**

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

Standard: Manufacturer's standard

Tolerance nominal Ø: j6

Number of cutting edges Z: 2

Tolerance nominal Ø: j6

recommended maximum drilling depth L_2 : 294 mm

Overall length L: 364 mm

Shank Ø D_s : 14 mm

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

Technical description

| | |
|---|-------------------------|
| Feed f in steel < 900 N/mm ² | 0.24 mm/rev. |
| Overall length L | 364 mm |
| Standard | Manufacturer's standard |
| recommended maximum drilling depth L ₂ | 294 mm |
| Shank Ø D _s | 14 mm |
| Nominal Ø D _c | 14 mm |
| Flute length L _c | 315 mm |
| Tolerance nominal Ø | j6 |
| Number of cutting edges Z | 2 |
| Series | GARANT Master Steel |
| Coating | TiAlN |
| Tool material | Solid carbide |
| Drill depth up to | 20xD |
| 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 |