Garant

GARANT Master Steel DEEP solid carbide deep-hole drill, plain shank DIN 6535 HA 20×D, TiAlN, ∅ DC: 9 mm

Order data

Order number	123890 9
GTIN	4062406268244
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 ∅.
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 hole withpilot 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 ∅: j6
Number of cutting edges Z: 2
Tolerance nominal ∅: j6
Overall length L: 249 mm
Shank ∅ D_s: 10 mm
Feed f in steel < 900 N/mm^2: 0.19 mm/rev.

Technical description

Overall length L	249 mm
Flute length L_c	203 mm
Shank ⌀ D_s	10 mm
Number of cutting edges Z	2
Nominal ⌀ D_C	9 mm
Feed f in steel < 900 N/mm^2	0.19 mm/rev.
Tolerance nominal ⌀	j6
Standard	Manufacturer's standard
Series	GARANT Master Steel
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	20×D
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