

## Garant

### GARANT Master Steel DEEP solid carbide deep-hole drill, plain shank DIN 6535 HA 30×D, TiAlN, Ø DC j6: 14 mm



#### Order data

Order number	123895 14
GTIN	4062406269142
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 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

Overall length L: 504 mm

Shank Ø D<sub>s</sub>: 14 mm

Feed f in steel < 900 N/mm<sup>2</sup>: 0.24 mm/rev.

#### Technical description

Flute length $L_c$	455 mm
Nominal $\varnothing D_c$	14 mm
Shank $\varnothing D_s$	14 mm
Feed $f$ in steel < 900 N/mm <sup>2</sup>	0.24 mm/rev.
Number of cutting edges $Z$	2
Tolerance nominal $\varnothing$	j6
Overall length $L$	504 mm
Standard	Manufacturer's standard
Series	GARANT Master Steel
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	30xD
Point angle	138 degrees
Shank	DIN 6535 HA to h5
Through-coolant	yes, with 40 bar
Machining strategy	HPC
Pilot drill required	yes, pilot drill
Colour ring	green
Type of product	Jobber drill