

**Garant**
**GARANT Master Steel DEEP solid carbide deep-hole drill, plain shank DIN 6535 HA 30×D, TiAlN, Ø DC j6: 6 mm**

**Order data**

Order number	123895 6
GTIN	4062406268923
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: 235 mm

Shank Ø  $D_s$ : 6 mm

Feed  $f$  in steel < 900 N/mm<sup>2</sup>: 0.14 mm/rev.

**Technical description**

Overall length L	235 mm
Standard	Manufacturer's standard
Shank Ø D <sub>s</sub>	6 mm
Number of cutting edges Z	2
Nominal Ø D <sub>c</sub>	6 mm
Flute length L <sub>c</sub>	195 mm
Feed f in steel < 900 N/mm <sup>2</sup>	0.14 mm/rev.
Tolerance nominal Ø	j6
Series	GARANT Master Steel
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	30×D
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