

Garant

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



Order data

Order number	123888 3
GTIN	4062406263003
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.

Note:

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

For process reliability when using the 16xD deep-hole drill, an initial centre drilling with No. 121068 – 121121 or at least 4xD pilot drilling operation with pilot drill No. 123885 is necessary. For deep holes greater than 20xD, 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 : 55.5 mm

Overall length L: 103 mm

Shank Ø D_s : 6 mm

Feed f in steel < 900 N/mm²: 0.07 mm/rev.

Technical description

recommended maximum drilling depth L_2	55.5 mm
Feed f in steel $< 900 \text{ N/mm}^2$	0.07 mm/rev.
Tolerance nominal \varnothing	j6
Number of cutting edges Z	2
Flute length L_c	60 mm
Overall length L	103 mm
Shank $\varnothing D_s$	6 mm
Nominal $\varnothing D_c$	3 mm
Standard	Manufacturer's standard
Series	Master Steel
Coating	TiAlN
Tool material	Solid carbide
Version	16xD
Point angle	138°
Shank	DIN 6535 HA to h6
Through-coolant	yes, with 40 bar
Machining strategy	HPC
Pilot drill required	yes, pilot drill
Colour ring	green
Type of product	Jobber drill

User data

	Suitability	V_c	ISO code
Steel $< 500 \text{ N/mm}^2$	suitable only under restricted conditions	125 m/min	P
Steel $< 750 \text{ N/mm}^2$	suitable	115 m/min	P
Steel $< 900 \text{ N/mm}^2$	suitable only under restricted conditions	110 m/min	P
Steel $< 1100 \text{ N/mm}^2$	suitable	110 m/min	P

Steel < 1400 N/mm ²	suitable	90 m/min	P
INOX < 900 N/mm ²	suitable	65 m/min	M
INOX > 900 N/mm ²	suitable only under restricted conditions	60 m/min	M
Ti > 850 N/mm ²	suitable only under restricted conditions	30 m/min	S
GG(G)	suitable only under restricted conditions	115 m/min	K
Uni	suitable		
wet maximum	suitable only under restricted conditions		
wet minimum	suitable only under restricted conditions		