Garant

GARANT Master Steel DEEP solid carbide deep-hole drill, plain shank DIN 6535 HA 30×D, TiAlN, ∅ DC j6: 3mm

Order data

Order number	123895 3
GTIN	4062406266233
Item class	10E

Description

Version:
Excellent chip evacuation due to the unequal helical pitch of the flutes, guide rings and additional flute lands 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 $L_C = L_2 + 1.5 \times D_C$.
Standard: Manufacturer's standard
Tolerance nominal ∅: j6
Number of cutting edges Z: 2
Tolerance nominal ∅: j6
recommended maximum drilling depth L_2: 99.5 mm
Overall length L: 147 mm
Shank ∅ D_s: 6 mm
Feed f in steel < 900 N/mm^2: 0.07 mm/rev.

Technical description

Nominal ∅ D_C	3 mm
Overall length L	147 mm
Shank ∅ D_s	6 mm
Standard	Manufacturer's standard

recommended maximum drilling depth L_2	99.5 mm
Feed f in steel < 900 N/mm²	0.07 mm/rev.
Flute length L_c	104 mm
Tolerance nominal ∅	j6
Number of cutting edges Z	2
Series	Master Steel
Coating	TiAlN
Tool material	Solid carbide
Version	30×D
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 N/mm²	suitable	105 m/min	P
Steel < 750 N/mm²	suitable	95 m/min	P
Steel < 900 N/mm²	suitable	85 m/min	P
Steel < 1100 N/mm²	suitable	85 m/min	P
Steel < 1400 N/mm²	suitable	70 m/min	P
INOX < 900 N/mm²	suitable	55 m/min	M
INOX > 900 N/mm²	suitable only under restricted conditions	50 m/min	M
GG(G)	suitable	95 m/min	K
Uni	suitable		

wet maximum	suitable
wet minimum	suitable only under restricted conditions