

## Garant

### Solid carbide drill-reamer with plain shank DIN 6535 HA, TiAlN, Ø DC: 11,97 mm



#### Order data

Order number	122795 11,97
GTIN	4062406102852
Item class	11P

#### Description

##### Version:

**Drilling and reaming in a single operation.** Very high concentricity. With **4 reaming cutting edges** for optimum dimensional accuracy and surface quality as good as reaming.

##### Recommendation:

##### Maximum drilling depth:

flute length (see table) less 1.5×nominal Ø.

##### Note:

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

Form HB and HE supplied at the same price as HA.

Form **HB**: order with **No. 122795 + 129100HB**.

Form **HE**: order with **No. 122795 + 129100HE**.

Through-coolant: yes, with 25 bar

Bore Ø tolerance: ±0.003

Standard: Manufacturer's standard

Number of cutting edges Z: 2

Bore Ø tolerance: ±0.003

recommended maximum drilling depth  $L_2$ : 53 mm

Overall length L: 118 mm

Shank Ø  $D_s$ : 12 mm

Feed f in steel < 900 N/mm<sup>2</sup>: 0.32 mm/rev.

#### Technical description

Standard	Manufacturer's standard
Shank tolerance	h6

recommended maximum drilling depth $L_2$	53 mm
Number of cutting edges Z	2
Feed f in steel < 900 N/mm <sup>2</sup>	0.32 mm/rev.
Nominal $\varnothing D_c$	11.97 mm
Flute length $L_c$	71 mm
Overall length L	118 mm
Shank $\varnothing D_s$	12 mm
Bore $\varnothing$ tolerance	$\pm 0.003$
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	5×D
Point angle	140°
Shank	DIN 6535 HA to h6
Through-coolant	yes, with 25 bar
Colour ring	without
Type of product	Jobber drill

## User data

	Suitability	$V_c$	ISO code
Aluminium (short chipping)	suitable	80 m/min	N
Alu > 10% Si	suitable	80 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	65 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	60 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	55 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	35 m/min	P
GG(G)	suitable	60 m/min	K
wet maximum	suitable		
wet minimum	suitable		

Air  
**Services** suitable

Shank grinding Type HB

129100 HB

Shank grinding Type HE

129100 HE