

Garant

Solid carbide drill-reamer with plain shank DIN 6535 HA, TiAlN, Ø DC: 12,68 mm



Order data

| | |
|--------------|---------------|
| Order number | 122795 12,68 |
| GTIN | 4062406102876 |
| 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 : 58 mm

Overall length L: 124 mm

Shank Ø D_s : 14 mm

Feed f in steel < 900 N/mm²: 0.32 mm/rev.

Technical description

| | |
|------------------------------------------|--------|
| recommended maximum drilling depth L_2 | 58 mm |
| Overall length L | 124 mm |

| | |
|-----------------------------------------|-------------------------|
| Nominal $\varnothing D_c$ | 12.68 mm |
| Shank $\varnothing D_s$ | 14 mm |
| Standard | Manufacturer's standard |
| Feed f in steel < 900 N/mm ² | 0.32 mm/rev. |
| Flute length L_c | 77 mm |
| Shank tolerance | h6 |
| Number of cutting edges Z | 2 |
| Bore \varnothing tolerance | ± 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 ² | suitable | 65 m/min | P |
| Steel < 750 N/mm ² | suitable | 60 m/min | P |
| Steel < 900 N/mm ² | suitable | 55 m/min | P |
| Steel < 1100 N/mm ² | 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