

Garant
Solid carbide drill-reamer with plain shank DIN 6535 HA, TiAlN, Ø DC: 6,5 mm

Order data

| | |
|--------------|---------------|
| Order number | 122795 6,5 |
| GTIN | 4062406131036 |
| 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: H7

Standard: Manufacturer's standard

Number of cutting edges Z: 2

Bore Ø tolerance: H7

recommended maximum drilling depth L_2 : 43.5 mm

Overall length L: 91 mm

Shank Ø D_s : 8 mm

Feed f in steel < 900 N/mm²: 0.19 mm/rev.

Technical description

| | |
|------------------|--------|
| Shank tolerance | h6 |
| Bore Ø tolerance | H7 |
| Nominal Ø D_c | 6.5 mm |

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|--|-------------------------|
| Flute length L_c | 53 mm |
| Shank $\varnothing D_s$ | 8 mm |
| Overall length L | 91 mm |
| Number of cutting edges Z | 2 |
| recommended maximum drilling depth L_2 | 43.5 mm |
| Feed f in steel < 900 N/mm ² | 0.19 mm/rev. |
| Standard | Manufacturer's standard |
| Coating | TiAlN |
| Tool material | Solid carbide |
| Drill depth up to | 5xD |
| 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 | suitable | | |

Services

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|------------------------|-----------|
| Shank grinding Type HE | 129100 HE |
| Shank grinding Type HB | 129100 HB |