

**Garant**
**Solid carbide drill-reamer with plain shank DIN 6535 HA, TiAlN, Ø DC: 4,5 mm**

**Order data**

Order number	122795 4,5
GTIN	4062406131012
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  $L_2$ : 29.3 mm

Overall length L: 74 mm

Shank Ø  $D_s$ : 6 mm

Feed f in steel < 900 N/mm<sup>2</sup>: 0.14 mm/rev.

**Technical description**

Number of cutting edges Z	2
Feed f in steel < 900 N/mm <sup>2</sup>	0.14 mm/rev.
Flute length $L_c$	36 mm

Standard	Manufacturer's standard
Bore Ø tolerance	H7
Shank Ø D <sub>s</sub>	6 mm
Shank tolerance	h6
Overall length L	74 mm
recommended maximum drilling depth L <sub>2</sub>	29.3 mm
Nominal Ø D <sub>c</sub>	4.5 mm
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 <sub>c</sub>	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	suitable		

**Services**

Shank grinding Type HB	129100 HB
Shank grinding Type HE	129100 HE