

Garant

Solid carbide drill-reamer with plain shank DIN 6535 HA, TiAlN, Ø DC: 3,99 mm



Order data

Order number	122795 3,99
GTIN	4045197586209
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 : 30.1 mm

Overall length L: 74 mm

Shank Ø D_s : 6 mm

Feed f in steel < 900 N/mm²: 0.14 mm/rev.

Technical description

Nominal Ø D_c	3.99 mm
Number of cutting edges Z	2

Flute length L_c	36 mm
Feed f in steel $< 900 \text{ N/mm}^2$	0.14 mm/rev.
Shank tolerance	h6
Shank $\varnothing D_s$	6 mm
Overall length L	74 mm
Standard	Manufacturer's standard
recommended maximum drilling depth L_2	30.1 mm
Bore \varnothing tolerance	H7
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 $> 10\% \text{ Si}$	suitable	80 m/min	N
Steel $< 500 \text{ N/mm}^2$	suitable	65 m/min	P
Steel $< 750 \text{ N/mm}^2$	suitable	60 m/min	P
Steel $< 900 \text{ N/mm}^2$	suitable	55 m/min	P
Steel $< 1100 \text{ N/mm}^2$	suitable	35 m/min	P
GG(G)	suitable	60 m/min	K
wet maximum	suitable		
wet minimum	suitable		

Air
Services suitable

Shank grinding Type HE

129100 HE

Shank grinding Type HB

129100 HB