

Garant
Solid carbide drill-reamer with pyramid tip DIN 6535 HA, TiAlN, Ø DC: 9H7mm

Order data

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|--------------|---------------|
| Order number | 122797 9H7 |
| GTIN | 4062406652364 |
| Item class | 11P |

Description
Version:

For producing toleranced holes in steel or short-chipping materials. **Reliable complete machining** without separate centring and without subsequent reaming process. Significantly improved self-centring due to **additional pyramid tip** for optimum roundness and tolerance accuracy of the hole that is produced. Two drill cutting edges and four reaming cutting edges for an attractive surface quality of the wall of the bore.

Tolerance specifications:

H7: Version for H7 bore tolerance.

+/- 0.003 mm: Manufacturing or cutting tolerance of nominal Ø D_c

Note:

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

HB and HE shanks are available at the same price as HA.

For **HB shanks:** use order **No. 122797 + 129100HB**.

For **HE shanks:** use order **No. 122797 + 129100HE**.

Technical description

| | |
|---|--------------|
| Feed f in steel < 900 N/mm ² | 0.17 mm/rev. |
| recommended maximum drilling depth L ₂ | 47.5 mm |
| Number of cutting edges Z | 2 |
| Nominal Ø D _c | 9 mm |
| Shank Ø D _s | 10 mm |
| Overall length L | 103 mm |
| Flute length L _c | 61 mm |

| | |
|-----------------|-------------------------|
| Standard | Manufacturer's standard |
| Tolerance | H7 |
| Coating | TiAlN |
| Tool material | Solid carbide |
| Version | 5×D |
| Point angle | 140 degrees |
| Shank | DIN 6535 HA with h6 |
| Through-coolant | yes, with 25 bar |
| Semi-Standard | yes |
| Colour ring | green |
| Type of product | Jobber drill |

User data

| | Suitability | V _c | ISO code |
|--------------------------------|-------------|----------------|----------|
| Steel < 500 N/mm ² | suitable | 100 m/min | P |
| Steel < 750 N/mm ² | suitable | 90 m/min | P |
| Steel < 900 N/mm ² | suitable | 80 m/min | P |
| Steel < 1100 N/mm ² | suitable | 70 m/min | P |
| Steel < 1400 N/mm ² | suitable | 60 m/min | P |
| GG(G) | suitable | 90 m/min | K |
| wet maximum | suitable | | |
| wet minimum | suitable | | |
| Air | suitable | | |

Services

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