

Garant

Solid carbide drill-reamer with pyramid tip DIN 6535 HA, TiAlN, Ø DC: 4,02mm



Order data

Order number	122797 4,02
GTIN	4062406989187
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

Tolerance	± 0.003
Number of cutting edges Z	2
Flute length L _c	36 mm
Standard	Manufacturer's standard
Shank Ø D _s	6 mm
Overall length L	74 mm

recommended maximum drilling depth L_2	30 mm
Nominal $\varnothing D_c$	4.02 mm
Feed f in steel $< 900 \text{ N/mm}^2$	0.13 mm/rev.
Coating	TiAlN
Tool material	Solid carbide
Version	5xD
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 $< 500 \text{ N/mm}^2$	suitable	100 m/min	P
Steel $< 750 \text{ N/mm}^2$	suitable	90 m/min	P
Steel $< 900 \text{ N/mm}^2$	suitable	80 m/min	P
Steel $< 1100 \text{ N/mm}^2$	suitable	70 m/min	P
Steel $< 1400 \text{ N/mm}^2$	suitable	60 m/min	P
GG(G)	suitable	90 m/min	K
wet maximum	suitable		
wet minimum	suitable		
Air	suitable		

Services

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

