

Garant**GARANT Uni Hero solid carbide drill plain shank DIN 6535 HA, TiAlSiN, Ø DC h7: 3,9mm****Order data**

Order number	122450 3,9
GTIN	4069515009195
Item class	13M

Description**Version:**

The ultimate in universality and profitability in one tool. **Robust tool design** and **convex-concave curved cutting edge design** for optimum tool stability and chip breakage behaviour in a wide range of materials. **Special flute geometry** and **polished flutes** for ideal chip evacuation and maximum process reliability. **Ultra-smooth TiAlSiN high-performance coating** to effectively reduce wear and the formation of built-up edges.

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. 122451**.

For **HE shanks**: order with **No. 122450** and **12900HE**.

Articles with prices in brackets: Different delivery time and minimum order quantity is 3 pieces.

Technical description

Flute length L_c	24 mm
Standard	DIN 6537 K
recommended maximum drilling depth L_2	18.2 mm
Nominal $\varnothing D_c$	3.9 mm
Shank $\varnothing D_s$	6 mm
Overall length L	66 mm
Feed f in steel $< 1100 \text{ N/mm}^2$	0.11 mm/rev.

Data sheet

Tolerance nominal Ø	h7
Number of cutting edges Z	2
Series	Uni
Coating	TiAlSiN
Tool material	Solid carbide
Version	4xD
Point angle	140 degrees
Shank	DIN 6535 HA to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Semi-Standard	yes
Colour ring	orange
Type of product	Jobber drill

User data

	Suitability	V _c	ISO code
Alu plastics	suitable only under restricted conditions	190 m/min	N
Aluminium (short chipping)	suitable	200 m/min	N
Steel < 500 N/mm ²	suitable	160 m/min	P
Steel < 750 N/mm ²	suitable	150 m/min	P
Steel < 900 N/mm ²	suitable	140 m/min	P
Steel < 1100 N/mm ²	suitable	110 m/min	P
Steel < 1400 N/mm ²	suitable	90 m/min	P
INOX < 900 N/mm ²	suitable	90 m/min	M
INOX > 900 N/mm ²	suitable	80 m/min	M
Ti > 850 N/mm ²	suitable	40 m/min	S
GG(G)	suitable	130 m/min	K

Uni	suitable
wet maximum	suitable
wet minimum	suitable
Air	suitable only under restricted conditions

Suitable products

<https://www.hoffmann-group.com/GB/en/hom/p/122450-3,9>