

**Garant****GARANT Uni Hero solid carbide drill plain shank DIN 6535 HA, TiAlSiN, Ø DC h7: 13,8mm****Order data**

|              |               |
|--------------|---------------|
| Order number | 122700 13,8   |
| GTIN         | 4069515010986 |
| 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. 122701**.

**HE shank**: order with **No. 122700** and **12900HE**.

Items with prices in brackets: Differing delivery time and minimum order quantity 3 pieces.

**Technical description**

|                                          |              |
|------------------------------------------|--------------|
| Number of cutting edges Z                | 2            |
| Feed f in steel < 1100 N/mm <sup>2</sup> | 0.26 mm/rev. |
| Tolerance nominal Ø                      | h7           |
| Flute length $L_c$                       | 77 mm        |
| Standard                                 | DIN 6537 L   |
| recommended maximum drilling depth $L_2$ | 56.3 mm      |
| Shank Ø $D_s$                            | 14 mm        |

## Data sheet

|                           |                    |
|---------------------------|--------------------|
| Overall length L          | 124 mm             |
| Nominal $\varnothing D_c$ | 13.8 mm            |
| Series                    | Uni                |
| Coating                   | TiAlSiN            |
| Tool material             | Solid carbide      |
| Version                   | 6xD                |
| 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           | Mono jobber drills |

## 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 <sup>2</sup>  | suitable                                  | 160 m/min | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable                                  | 150 m/min | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable                                  | 140 m/min | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable                                  | 110 m/min | P        |
| Steel < 1400 N/mm <sup>2</sup> | suitable                                  | 90 m/min  | P        |
| INOX < 900 N/mm <sup>2</sup>   | suitable                                  | 90 m/min  | M        |
| INOX > 900 N/mm <sup>2</sup>   | suitable                                  | 80 m/min  | M        |
| Ti > 850 N/mm <sup>2</sup>     | suitable                                  | 40 m/min  | S        |
| GG(G)                          | suitable                                  | 130 m/min | K        |

|             |                                              |
|-------------|----------------------------------------------|
| Uni         | suitable                                     |
| wet maximum | suitable                                     |
| wet minimum | suitable                                     |
| Air         | suitable only under<br>restricted conditions |

**Suitable products**

<https://www.hoffmann-group.com/GB/en/hom/p/122700-13,8>