

**Garant****GARANT Uni Hero solid carbide drill plain shank DIN 6535 HA, TiAlSiN, Ø DC h7: 7,1mm****Order data**

Order number	122450 7,1
GTIN	4069515009515
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**

Feed f in steel < 1100 N/mm <sup>2</sup>	0.17 mm/rev.
Standard	DIN 6537 K
Nominal Ø D <sub>c</sub>	7.1 mm
Flute length L <sub>c</sub>	41 mm
Number of cutting edges Z	2
Tolerance nominal Ø	h7
Overall length L	79 mm

## Data sheet

recommended maximum drilling depth $L_2$	30.4 mm
Shank $\varnothing D_s$	8 mm
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 <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 restricted conditions

**Suitable products**

<https://www.hoffmann-group.com/GB/en/hom/p/122450-7,1>