Data sheet

GARANT Uni Hero solid carbide drill plain shank DIN 6535 HA, TiAlSiN, ⌀ DC h7: 2,8mm

Order data

Order number	122700 2,8
GTIN	4069515011464
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
Tolerance nominal ⌀	h7
Overall length L	57 mm
Nominal ⌀ D_C	2.8 mm
Shank ⌀ D_s	4 mm
recommended maximum drilling depth L_2	17.8 mm
Flute length L_c	22 mm

Standard	DIN 6537 L
Feed f in steel < 1100 N/mm²	0.08 mm/rev.
Series	Uni
Coating	TiAlSiN
Tool material	Solid carbide
Version	6×D
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/mm²	suitable	160 m/min	P
Steel < 750 N/mm²	suitable	150 m/min	P
Steel < 900 N/mm²	suitable	140 m/min	P
Steel < 1100 N/mm²	suitable	110 m/min	P
Steel < 1400 N/mm²	suitable	90 m/min	P
INOX < 900 N/mm²	suitable	90 m/min	M
INOX > 900 N/mm²	suitable	80 m/min	M
Ti > 850 N/mm²	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