

**Garant****GARANT Uni Hero solid carbide drill plain shank DIN 6535 HA, TiAlSiN, Ø DC h7: 4,65mm****Order data**

|              |               |
|--------------|---------------|
| Order number | 122700 4,65   |
| GTIN         | 4069515014779 |
| 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**

|                                                   |              |
|---------------------------------------------------|--------------|
| Nominal Ø D <sub>C</sub>                          | 4.65 mm      |
| Standard                                          | DIN 6537 L   |
| recommended maximum drilling depth L <sub>2</sub> | 29 mm        |
| Feed f in steel < 1100 N/mm <sup>2</sup>          | 0.13 mm/rev. |
| Number of cutting edges Z                         | 2            |
| Shank Ø D <sub>s</sub>                            | 6 mm         |
| Tolerance nominal Ø                               | h7           |

## Data sheet

|                             |                    |
|-----------------------------|--------------------|
| Overall length L            | 74 mm              |
| Flute length L <sub>c</sub> | 36 mm              |
| 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 <sub>c</sub> | 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/122700-4,65>