Data sheet

GARANT Uni Hero solid carbide drill, plain shank DIN 6535 HB, TiAlSiN, ⌀ DC h7: 5,3mm

Order data

Order number	122701 5,3
GTIN	4069515033565
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 in a wide range of materials. **Special chip chamber geometry** and **polished chip chambers** 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 $L_C = L_2 + 1.5 \times D_C$.

Technical description

Number of cutting edges Z	2
Overall length L	82 mm
Tolerance nominal ⌀	h7
Standard	DIN 6537 L
Nominal ⌀ D_C	5.3 mm
Flute length L_c	44 mm
recommended maximum drilling depth L_2	36.1 mm
Feed f in steel < 1100 N/mm^2	0.14 mm/rev.
Shank ⌀ D_s	6 mm
Series	Uni

Coating	TiAlSiN
Tool material	Solid carbide
Version	4×D
Point angle	140 degrees
Shank	DIN 6535 HB to h6
Through-coolant	yes
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 only under restricted conditions	90 m/min	M
INOX > 900 N/mm²	suitable only under restricted conditions	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