

**Garant**

**GARANT Uni Hero solid carbide drill, plain shank DIN 6535 HB, TiAlSiN, Ø DC h7: 6,1mm**



## Order data

|              |               |
|--------------|---------------|
| Order number | 122451 6,1    |
| GTIN         | 4069515032667 |
| 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

|                                          |              |
|------------------------------------------|--------------|
| Standard                                 | DIN 6537 K   |
| recommended maximum drilling depth $L_2$ | 24.9 mm      |
| Tolerance nominal Ø                      | h7           |
| Nominal Ø $D_c$                          | 6.1 mm       |
| Number of cutting edges Z                | 2            |
| Flute length $L_c$                       | 34 mm        |
| Shank Ø $D_s$                            | 8 mm         |
| Overall length L                         | 79 mm        |
| Feed f in steel < 1100 N/mm <sup>2</sup> | 0.15 mm/rev. |
| Series                                   | Uni          |

## Data sheet

|                    |                   |
|--------------------|-------------------|
| Coating            | TiAlSiN           |
| Tool material      | Solid carbide     |
| Version            | 4xD               |
| Point angle        | 140 degrees       |
| Shank              | DIN 6535 HB 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 <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  
restricted conditions