

Garant

GARANT Uni Hero solid carbide drill, plain shank DIN 6535 HB, TiAlSiN, Ø DC h7: 8,5mm



Order data

Order number	122451 8,5
GTIN	4069515032902
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
Nominal Ø D_c	8.5 mm
recommended maximum drilling depth L_2	34.3 mm
Tolerance nominal Ø	h7
Feed f in steel $< 1100 \text{ N/mm}^2$	0.2 mm/rev.
Flute length L_c	47 mm
Shank Ø D_s	10 mm
Number of cutting edges Z	2
Overall length L	89 mm
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 _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 ²	suitable	160 m/min	P
Steel < 750 N/mm ²	suitable	150 m/min	P
Steel < 900 N/mm ²	suitable	140 m/min	P
Steel < 1100 N/mm ²	suitable	110 m/min	P
Steel < 1400 N/mm ²	suitable	90 m/min	P
INOX < 900 N/mm ²	suitable	90 m/min	M
INOX > 900 N/mm ²	suitable	80 m/min	M
Ti > 850 N/mm ²	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