

Garant

GARANT Uni Hero solid carbide drill, plain shank DIN 6535 HA, TiAlSiN, Ø DC h7: 8,6mm



Order data

Order number	GG1255 8,6
GTIN	4067263106562
Item class	GGN

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.

Same as number: 123020.

Form HB available with No. GG1258 at the same price.

Note:

Flute length $L_c = L_2 + 1.5 \times D_c$.

Articles with prices in brackets: Different delivery time and minimum order quantity is 3 pieces.

Technical description

Feed f in steel $< 1100 \text{ N/mm}^2$	0.18 mm/rev.
Flute length L_c	95 mm
recommended maximum drilling depth L_2	82.1 mm

Data sheet

Contents	5"
Shank Ø D _s	10 mm
Standard	Manufacturer's standard
Nominal Ø D _c	8.6 mm
Overall length L	142 mm
Tolerance nominal Ø	h7
Number of cutting edges Z	2
Coating	TiAlSiN
Tool material	Solid carbide
Version	8xD
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	Jobber drill

User data

	Suitability	V _c	ISO code
Alu plastics	suitable only under restricted conditions	140 m/min	N
Aluminium (short chipping)	suitable	150 m/min	N
Steel < 500 N/mm ²	suitable	120 m/min	P
Steel < 750 N/mm ²	suitable	115 m/min	P
Steel < 900 N/mm ²	suitable	110 m/min	P
Steel < 1100 N/mm ²	suitable	80 m/min	P
Steel < 1400 N/mm ²	suitable	70 m/min	P

Data sheet

INOX < 900 N/mm ²	suitable	65 m/min	M
INOX > 900 N/mm ²	suitable	60 m/min	M
Ti > 850 N/mm ²	suitable	35 m/min	S
GG(G)	suitable	95 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable		
Air	suitable only under restricted conditions		

Suitable products

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