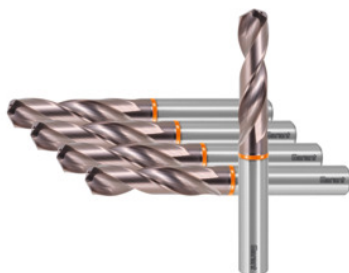


**Garant**

**GARANT Uni Hero solid carbide drill, plain shank DIN 6535 HA, TiAlSiN, Ø DC h7: 15,5mm**



## Order data

Order number	GG1253 15,5
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: 122450**

Form HB available with No. GG1256 at the same price.

Form HB only available from  $\geq 3$  mm.

### 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

Flute length $L_c$	65 mm
Tolerance nominal $\varnothing$	h7
Shank $\varnothing D_s$	16 mm

## Data sheet

Contents	5"
Standard	DIN 6537 K
Nominal $\varnothing D_c$	15.5 mm
recommended maximum drilling depth $L_2$	41.8 mm
Feed $f$ in steel $< 1100 \text{ N/mm}^2$	0.27 mm/rev.
Overall length $L$	115 mm
Number of cutting edges $Z$	2
Coating	TiAlSiN
Tool material	Solid carbide
Version	4xD
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	190 m/min	N
Aluminium (short chipping)	suitable	200 m/min	N
Steel $< 500 \text{ N/mm}^2$	suitable	160 m/min	P
Steel $< 750 \text{ N/mm}^2$	suitable	150 m/min	P
Steel $< 900 \text{ N/mm}^2$	suitable	140 m/min	P
Steel $< 1100 \text{ N/mm}^2$	suitable	110 m/min	P
Steel $< 1400 \text{ N/mm}^2$	suitable	90 m/min	P

## Data sheet

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		

### Suitable products

No Shop URL available for: GG1253 15,5