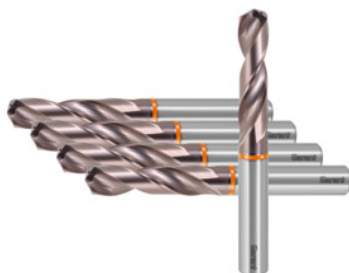


Garant

GARANT Uni Hero solid carbide drill, plain shank DIN 6535 HA, TiAlSiN, Ø DC h7: 3,2mm



Order data

Order number	GG1253 3,2
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 ≥ 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

Number of cutting edges Z	2
Overall length L	62 mm
Flute length L_c	20 mm

Data sheet

Contents	5"
recommended maximum drilling depth L_2	15.2 mm
Standard	DIN 6537 K
Feed f in steel $< 1100 \text{ N/mm}^2$	0.09 mm/rev.
Nominal $\varnothing D_c$	3.2 mm
Shank $\varnothing D_s$	6 mm
Tolerance nominal \varnothing	h7
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 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		

Suitable products

No Shop URL available for: GG1253 3,2