

**Garant**

**GARANT Uni Hero solid carbide drill, plain shank DIN 6535 HA, TiAlSiN, Ø DC h7: 6,9mm**



## Order data

|              |               |
|--------------|---------------|
| Order number | GG1253 6,9    |
| 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 $L_c$        | 34 mm  |
| Overall length $L$        | 79 mm  |
| Nominal $\varnothing D_c$ | 6.9 mm |

## Data sheet

|                                                   |                   |
|---------------------------------------------------|-------------------|
| Feed f in steel < 1100 N/mm <sup>2</sup>          | 0.17 mm/rev.      |
| Shank Ø D <sub>s</sub>                            | 8 mm              |
| recommended maximum drilling depth L <sub>2</sub> | 23.7 mm           |
| Contents                                          | 5"                |
| Number of cutting edges Z                         | 2                 |
| Standard                                          | DIN 6537 K        |
| Tolerance nominal Ø                               | h7                |
| Coating                                           | TiAlSiN           |
| Tool material                                     | Solid carbide     |
| Version                                           | 4×D               |
| 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 <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        |

## 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<br>restricted conditions |           |   |

### Suitable products

No Shop URL available for: GG1253 6,9