

Garant

GARANT Diabolo solid carbide HPC drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7 (mm or inch): 18



Order data

| | |
|--------------|---------------|
| Order number | 122361 18 |
| GTIN | 4062406098940 |
| Item class | 11E |

Description

Version:

Cutting chisel edge with **high centring accuracy** due to strong core and special point geometry. **Convex major cutting edges** with **defined honed edge** ensure the drill has high stability and maximum load capacity.

Special multi-nano layer coating for drilling in hardened steels.

Note:

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

Form HB and HE supplied at the same price as HA.

Form **HB**: order with **No. 122362 / 122372**.

Form **HE**: order with **No. 122361 / 122371 + 129100HE**.

Technical description

| | |
|---|--------------|
| Shank Ø D _s | 18 mm |
| Nominal Ø D _c | 18 mm |
| Standard | DIN 6537 K |
| Number of cutting edges Z | 2 |
| recommended maximum drilling depth L ₂ | 46 mm |
| Tolerance nominal Ø | h7 |
| Flute length L _c | 73 mm |
| Overall length L | 123 mm |
| Feed f in steel < 60 HRC | 0.15 mm/rev. |

| | |
|--------------------|-------------------|
| Series | Diabolo |
| Coating | TiAlN |
| Tool material | Solid carbide |
| Version | 4xD |
| Type | H |
| Point angle | 140 degrees |
| Shank | DIN 6535 HA to h6 |
| Through-coolant | no |
| Machining strategy | HPC |
| Semi-Standard | yes |
| Colour ring | red |
| Type of product | Jobber drill |

User data

| | Suitability | V _c | ISO code |
|--------------------------------|---|----------------|----------|
| Steel < 500 N/mm ² | suitable only under restricted conditions | 90 m/min | P |
| Steel < 750 N/mm ² | suitable only under restricted conditions | 80 m/min | P |
| Steel < 900 N/mm ² | suitable | 70 m/min | P |
| Steel < 1100 N/mm ² | suitable | 65 m/min | P |
| Steel < 1400 N/mm ² | suitable | 55 m/min | P |
| Steel < 55 HRC | suitable | 28 m/min | H |
| Steel < 60 HRC | suitable | 16 m/min | H |
| Steel < 65 HRC | suitable | 14 m/min | H |
| Steel < 67 HRC | suitable | 10 m/min | H |
| GG(G) | suitable | 70 m/min | K |
| wet maximum | suitable | | |
| dry | suitable | | |

Services

Shank grinding Type HE

129100 HE