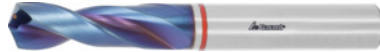


Garant

Diabolo solid carbide HPC drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7 (mm or inch): 1/16



Order data

Order number	122371 1/16
GTIN	4062406116781
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.

Recommendation:

Maximum drilling depth:

flute length (see table) less $1.5 \times \text{nominal } \varnothing$.

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**.

Standard: DIN 6537 K

Tolerance nominal \varnothing : h7

Number of cutting edges Z: 2

Tolerance nominal \varnothing : h7

recommended maximum drilling depth L_2 : 11.615 mm

Overall length L: 55 mm

Shank $\varnothing D_s$: 4 mm

Feed f in steel < 60 HRC: 0.01 mm/rev.

Technical description

Shank $\varnothing D_s$	4 mm
Inch nominal \varnothing corresponds to	1.59 mm

recommended maximum drilling depth L_2	11.615 mm
Number of cutting edges Z	2
Overall length L	55 mm
Standard	DIN 6537 K
Tolerance nominal \varnothing	h7
Flute length L_c	14 mm
Feed f in steel < 60 HRC	0.01 mm/rev.
Series	Diabolo
Coating	TiAlN
Tool material	Solid carbide
Version	4xD
Type	H
Point angle	140°
Shank	DIN 6535 HA to h6
Through-coolant	yes, with 25 bar
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	120 m/min	P
Steel < 750 N/mm ²	suitable	100 m/min	P
Steel < 900 N/mm ²	suitable	85 m/min	P
Steel < 1100 N/mm ²	suitable	70 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
TOOLOX 33	suitable	30 m/min	H
TOOLOX 44	suitable	28 m/min	H
HARDOX 500 < 1600 N/ mm ²	suitable	28 m/min	H
GG(G)	suitable	70 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable		
Air	suitable		