

## Garant

**Diabolo solid carbide HPC drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7 (mm or inch): 11/32**



### Order data

Order number	122371 11/32
GTIN	4062406116910
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  $L_2$ : 33.905 mm

Overall length L: 89 mm

Shank  $\varnothing D_s$ : 10 mm

Feed f in steel < 1100 N/mm<sup>2</sup>: 0.27 mm/rev.

Feed f in steel < 60 HRC: 0.12 mm/rev.

### Technical description

Feed f in steel < 1100 N/mm <sup>2</sup>	0.27 mm/rev.
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Standard	DIN 6537 K
Shank $\varnothing D_s$	10 mm
Feed $f$ in steel < 60 HRC	0.12 mm/rev.
Number of cutting edges $Z$	2
Flute length $L_c$	47 mm
Inch nominal $\varnothing$ corresponds to	8.73 mm
Tolerance nominal $\varnothing$	h7
recommended maximum drilling depth $L_2$	33.905 mm
Overall length $L$	89 mm
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 <sup>2</sup>	suitable only under restricted conditions	120 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	100 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	85 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	70 m/min	P

Steel < 1400 N/mm <sup>2</sup>	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 <sup>2</sup>	suitable	28 m/min	H
GG(G)	suitable	70 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable		
Air	suitable		

### Services

Shank grinding Type HE

129100 HE