

**Garant**
**GARANT Diabolo solid carbide HPC drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7 (mm or inch): 12,7**

**Order data**

Order number	122371 12,7
GTIN	4062406117016
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**

Standard	DIN 6537 K
Tolerance nominal Ø	h7
Nominal Ø $D_c$	12.7 mm
Feed $f$ in steel < 1100 N/mm <sup>2</sup>	0.32 mm/rev.
Overall length $L$	107 mm
recommended maximum drilling depth $L_2$	40.95 mm
Shank Ø $D_s$	14 mm
Flute length $L_c$	60 mm
Number of cutting edges $Z$	2

Feed f in steel < 60 HRC	0.16 mm/rev.
Series	Diabolo
Coating	TiAlN
Tool material	Solid carbide
Version	4×D
Type	H
Point angle	140 degrees
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 <sub>c</sub>	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
GG(G)	suitable	70 m/min	K
Uni	suitable		
wet maximum	suitable		

wet minimum	suitable
Air	suitable
<b>Services</b>	

Shank grinding Type HE	129100 HE
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