

**Garant**
**Diabolo solid carbide HPC drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 1/8mm**

**Order data**

Order number	122362 1/8
GTIN	4062406121327
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  $L_c = L_2 + 1.5 \times D_c$ .

Standard: DIN 6537 K

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

Tolerance nominal Ø: h7

recommended maximum drilling depth  $L_2$ : 15.23 mm

Overall length L: 62 mm

Shank Ø  $D_s$ : 6 mm

Feed f in steel < 60 HRC: 0.06 mm/rev.

**Technical description**

Flute length $L_c$	20 mm
Inch nominal Ø corresponds to	3.18 mm
Overall length L	62 mm
Number of cutting edges Z	2
Tolerance nominal Ø	h7
recommended maximum drilling depth $L_2$	15.23 mm

Feed f in steel < 60 HRC	0.06 mm/rev.
Standard	DIN 6537 K
Shank $\varnothing D_s$	6 mm
Series	Diabolo
Coating	TiAlN
Tool material	Solid carbide
Version	4xD
Type	H
Point angle	140°
Shank	DIN 6535 HB 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 <sup>2</sup>	suitable only under restricted conditions	90 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable only under restricted conditions	80 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	70 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	65 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 only under restricted conditions	30 m/min	H
TOOLOX 44	suitable only under restricted conditions	28 m/min	H
HARDOX 500 < 1600 N/mm <sup>2</sup>	suitable only under restricted conditions	28 m/min	H
GG(G)	suitable	70 m/min	K
Uni	suitable		
wet maximum	suitable		
dry	suitable		