

Garant

Diabolo solid carbide HPC drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 1/2mm



Order data

Order number	122362 1/2
GTIN	4062406121464
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 : 40.95 mm

Overall length L: 107 mm

Shank Ø D_s : 14 mm

Feed f in steel < 60 HRC: 0.13 mm/rev.

Technical description

Tolerance nominal Ø	h7
Shank Ø D_s	14 mm
Feed f in steel < 60 HRC	0.13 mm/rev.
Overall length L	107 mm
Number of cutting edges Z	2
Standard	DIN 6537 K

Flute length L_c	60 mm
Inch nominal \varnothing corresponds to	12.7 mm
recommended maximum drilling depth L_2	40.95 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 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

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 ²	suitable only under restricted conditions	28 m/min	H
GG(G)	suitable	70 m/min	K
Uni	suitable		
wet maximum	suitable		
dry	suitable		