



Diabolo solid carbide HPC drill, plain shank DIN 6535 HA, TiAlN, Ø h7: 13,8 mm

Order data

| | |
|--------------|---------------|
| Order number | 122536 13,8 |
| GTIN | 4045197541284 |
| Item class | 11E |

Description

Version:

GARANT Diabolo – cutting chisel edge with high centring accuracy – due to special point geometry and strong core. Convex major cutting edges with slightly honed edges and special flute profile for **short chips**.

Special coating for drilling in hardened steels.

Recommendation:

Maximum drilling depth:

Flute length (see table) less 1.5×nominal Ø.1

Note:

Form HB and HE supplied at the same price as HA.

Form **HB**: order with **No. 122538**.

Form **HE**: order with **No. 122536 + 129100HE**.

Tool material: Solid carbide

Drill depth up to: 6×D

Type: H

Point angle: 140 degrees

Skaft: DIN 6535 HA to h6

Machining strategy: HPC

Norm: DIN 6537

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

Tolerance nominal Ø: h7

Flute length: 77 mm

Overall length L_{tot} : 124 mm

Shank Ø: 14 mm

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

Technical description

| | |
|----------------------|-------------------|
| Tool material | Solid carbide |
| Hole tolerance | |
| Colour ring | red |
| Through-coolant | |
| Helix angle | degrees |
| Point angle | 140 degrees |
| Coating | TiAlN |
| Drill depth up to | 6×D |
| Cutting direction | |
| Pilot drill required | |
| Machining strategy | HPC |
| Type | H |
| Use for drilling | |
| Schaft | DIN 6535 HA to h6 |
| Series | Diabolo |
| Type of product | |