



## Diabolo solid carbide HPC drill, plain shank DIN 6535 HA, TiAlN, Ø h7: 7,8 mm

### Order data

Order number	122536 7,8
GTIN	4045197541116
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

Schaft: 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: 53 mm

Overall length  $L_{tot}$ : 91 mm

Shank Ø: 8 mm

Feed f in steel < 60 HRC: 0.09 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	
Skaft	DIN 6535 HA to h6
Series	Diabolo
Type of product	