



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

Order data

| | |
|--------------|---------------|
| Order number | 122536 8 |
| GTIN | 4045197541123 |
| 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 | |