



Diabolo solid carbide HPC drill, plain shank DIN 6535 HA, TiAlN, Ø h7: 8,5 mm

Order data

Order number	122536 8,5
GTIN	4045197541130
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: 61 mm

Overall length L_{tot} : 103 mm

Shank Ø: 10 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	