

Garant

Diabolo solid carbide HPC drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7: 1mm



Order data

| | |
|--------------|---------------|
| Order number | 122651 1 |
| GTIN | 4045197967848 |
| 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 $L_c = L_2 + 1.5 \times D_c$.

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

Form **HB**: order with **No. 122642 / 122652**.

Form **HE**: order with **No. 122641 / 122651 + 129100HE**.

When drilling in hardened steels from 56 HRC, only cool using air!

Technical description

| | |
|---------------------------|--------------|
| Number of cutting edges Z | 2 |
| Overall length L | 55 mm |
| Tolerance nominal Ø | h7 |
| Nominal Ø D_c | 1 mm |
| Shank Ø D_s | 4 mm |
| Flute length L_c | 8 mm |
| Standard | DIN 6537 |
| Feed f in steel < 60 HRC | 0.01 mm/rev. |

| | |
|------------------------------------------|-------------------|
| recommended maximum drilling depth L_2 | 6.5 mm |
| Series | Diabolo |
| Coating | TiAlN |
| Tool material | Solid carbide |
| Version | 6×D |
| Type | H |
| Point angle | 140 degrees |
| Shank | DIN 6535 HA to h6 |
| Through-coolant | yes, with 25 bar |
| 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 | 120 m/min | P |
| Steel < 750 N/mm ² | suitable | 100 m/min | P |
| Steel < 900 N/mm ² | suitable | 85 m/min | P |
| Steel < 1100 N/mm ² | suitable | 70 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 |
| GG(G) | suitable | 70 m/min | K |
| Uni | suitable | | |
| wet maximum | suitable | | |

| | |
|-------------|----------|
| wet minimum | suitable |
| Air | suitable |