

## Garant

### GARANT Diabolo solid carbide HPC drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7 (mm or inch): 3,5



#### Order data

|              |               |
|--------------|---------------|
| Order number | 122371 3,5    |
| GTIN         | 4045197969019 |
| 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. 122362 / 122372**.

Form **HE**: order with **No. 122361 / 122371 + 129100HE**.

#### Technical description

|  |              |
|--|--------------|
| Number of cutting edges Z                | 2            |
| Flute length $L_c$                       | 20 mm        |
| Shank $\varnothing D_s$                  | 6 mm         |
| Nominal $\varnothing D_c$                | 3.5 mm       |
| recommended maximum drilling depth $L_2$ | 14.8 mm      |
| Standard                                 | DIN 6537 K   |
| Overall length L                         | 62 mm        |
| Tolerance nominal $\varnothing$          | h7           |
| Feed f in steel < 60 HRC                 | 0.03 mm/rev. |

|                    |                   |
|--------------------|-------------------|
| Series             | Diabolo           |
| Coating            | TiAlN             |
| Tool material      | Solid carbide     |
| Version            | 4xD               |
| 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 <sub>c</sub> | ISO code |
|--------------------------------|---|----------------|----------|
| Steel < 500 N/mm <sup>2</sup>  | suitable only under restricted conditions | 120 m/min      | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable                                  | 100 m/min      | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable                                  | 85 m/min       | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable                                  | 70 m/min       | P        |
| Steel < 1400 N/mm <sup>2</sup> | 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  
**Services**

suitable

Shank grinding Type HE

129100 HE