

**Garant**
**Diabolo solid carbide HPC drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7: 13mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 122641 13     |
| GTIN         | 4045197969743 |
| 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**.

**Technical description**

|   |              |
|---|--------------|
| Number of cutting edges Z                         | 2            |
| Standard  | DIN 6537     |
| Overall length L                                  | 124 mm       |
| Feed f in steel < 60 HRC                          | 0.13 mm/rev. |
| Shank Ø D <sub>s</sub>                            | 14 mm        |
| Flute length L <sub>c</sub>                       | 77 mm        |
| recommended maximum drilling depth L <sub>2</sub> | 57.5 mm      |
| Nominal Ø D <sub>c</sub>                          | 13 mm        |
| Tolerance nominal Ø                               | h7           |

|                    |                   |
|--------------------|-------------------|
| 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    | no                |
| 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 | 90 m/min       | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable only under restricted conditions | 80 m/min       | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable                                  | 70 m/min       | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable                                  | 65 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        |
| wet maximum                    | suitable                                  |                |          |
| dry                            | suitable                                  |                |          |

## Services

Shank grinding Type HE

129100 HE