

**Garant****GARANT Diabolo solid carbide HPC drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 8,5mm****Order data**

Order number	122372 8,5
GTIN	4045197971623
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  $L_c = L_2 + 1.5 \times D_c$ .

**Technical description**

Overall length L	89 mm
Nominal Ø $D_c$	8.5 mm
Flute length $L_c$	47 mm
recommended maximum drilling depth $L_2$	34.3 mm
Number of cutting edges Z	2
Standard	DIN 6537 K
Tolerance nominal Ø	h7
Feed f in steel < 1100 N/mm <sup>2</sup>	0.2 mm/rev.
Shank Ø $D_s$	10 mm
Feed f in steel < 60 HRC	0.12 mm/rev.
Series	Diabolo

Coating	TiAlN
Tool material	Solid carbide
Version	4xD
Type	H
Point angle	140 degrees
Shank	DIN 6535 HB 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
TOOLOX 33	suitable	30 m/min	H
TOOLOX 44	suitable	28 m/min	H
HARDOX 500 < 1600 N/mm <sup>2</sup>	suitable	28 m/min	H
GG(G)	suitable	70 m/min	K

## Data sheet

Uni	suitable
wet maximum	suitable
wet minimum	suitable
Air	suitable