

Garant**GARANT Diabolo solid carbide HPC drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 4,2mm****Order data**

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|--------------|---------------|
| Order number | 122372 4,2 |
| GTIN | 4045197971456 |
| 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

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|---|--------------|
| Feed f in steel < 60 HRC | 0.04 mm/rev. |
| Shank Ø D _s | 6 mm |
| Feed f in steel < 1100 N/mm ² | 0.15 mm/rev. |
| Tolerance nominal Ø | h7 |
| Flute length L _c | 24 mm |
| Nominal Ø D _c | 4.2 mm |
| recommended maximum drilling depth L ₂ | 17.7 mm |
| Standard | DIN 6537 K |
| Number of cutting edges Z | 2 |
| Overall length L | 66 mm |
| Series | Diabolo |

Data sheet

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|--------------------|-------------------|
| 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 _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 |
| TOOLOX 33 | suitable | 30 m/min | H |
| TOOLOX 44 | suitable | 28 m/min | H |
| HARDOX 500 < 1600 N/mm ² | suitable | 28 m/min | H |
| GG(G) | suitable | 70 m/min | K |

Data sheet

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|-------------|----------|
| Uni | suitable |
| wet maximum | suitable |
| wet minimum | suitable |
| Air | suitable |