Garant

GARANT Diabolo solid carbide HPC drill, plain shank DIN 6535 HB, TiAlN, ∅ DC h7: 8,5mm

Order data

Order number	122362 8,5
GTIN	4045197971104
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
Number of cutting edges Z	2
Flute length L_c	47 mm
Tolerance nominal ∅	h7
recommended maximum drilling depth L_2	34.3 mm
Nominal ∅ D_C	8.5 mm
Standard	DIN 6537 K
Feed f in steel < 60 HRC	0.11 mm/rev.
Shank ∅ D_s	10 mm
Series	Diabolo
Coating	TiAlN

Tool material	Solid carbide
Version	4×D
Type	H
Point angle	140 degrees
Shank	DIN 6535 HB to h6
Through-coolant	no
Machining strategy	HPC
Semi-Standard	yes
Colour ring	red
Type of product	Jobber drill

User data

	Suitability	V_c	ISO code
Steel < 500 N/mm²	suitable only under restricted conditions	90 m/min	P
Steel < 750 N/mm²	suitable only under restricted conditions	80 m/min	P
Steel < 900 N/mm²	suitable	70 m/min	P
Steel < 1100 N/mm²	suitable	65 m/min	P
Steel < 1400 N/mm²	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 only under restricted conditions	30 m/min	H
TOOLOX 44	suitable only under restricted conditions	28 m/min	H
HARDOX 500 < 1600 N/mm²	suitable only under restricted conditions	28 m/min	H

GG(G)	suitable	70 m/min	K
Uni	suitable		
wet maximum	suitable		
dry	suitable		