

## GARANT Diabolo solid carbide HPC drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 5,1mm



### Order data

|              |               |
|--------------|---------------|
| Order number | 122652 5,1    |
| GTIN         | 4045197972361 |
| 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

|  |              |
|--|--------------|
| Nominal Ø $D_c$                            | 5.1 mm       |
| Shank Ø $D_s$                              | 6 mm         |
| Flute length $L_c$                         | 44 mm        |
| Feed $f$ in steel < 1100 N/mm <sup>2</sup> | 0.15 mm/rev. |
| Number of cutting edges $Z$                | 2            |
| Standard                                   | DIN 6537     |
| recommended maximum drilling depth $L_2$   | 36.4 mm      |
| Overall length $L$                         | 82 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 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        |
| Uni                                 | suitable                                  |                |          |

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