

Garant**GARANT Diabolo solid carbide HPC drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 6,8mm****Order data**

| | |
|--------------|---------------|
| Order number | 122642 6,8 |
| GTIN | 4045197971920 |
| 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

| | |
|--|--------------|
| Flute length L_c | 53 mm |
| Feed f in steel < 60 HRC | 0.09 mm/rev. |
| Overall length L | 91 mm |
| Shank $\varnothing D_s$ | 8 mm |
| Nominal $\varnothing D_c$ | 6.8 mm |
| Standard | DIN 6537 |
| Tolerance nominal \varnothing | h7 |
| Number of cutting edges Z | 2 |
| recommended maximum drilling depth L_2 | 42.8 mm |
| Series | Diabolo |
| Coating | TiAlN |

Data sheet

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|--------------------|-------------------|
| Tool material | Solid carbide |
| Version | 6×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/mm ² | suitable only under restricted conditions | 90 m/min | P |
| Steel < 750 N/mm ² | suitable only under restricted conditions | 80 m/min | P |
| Steel < 900 N/mm ² | suitable | 70 m/min | P |
| Steel < 1100 N/mm ² | suitable | 65 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 only under restricted conditions | 30 m/min | H |
| TOOLOX 44 | suitable only under restricted conditions | 28 m/min | H |
| HARDOX 500 < 1600 N/mm ² | suitable only under restricted conditions | 28 m/min | H |

Data sheet

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