

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

Order number	122652 8,5
GTIN	4045197972569
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

Feed f in steel $< 1100 \text{ N/mm}^2$	0.2 mm/rev.
Shank $\varnothing D_s$	10 mm
Tolerance nominal \varnothing	h7
Flute length L_c	61 mm
Nominal $\varnothing D_c$	8.5 mm
Number of cutting edges Z	2
Standard	DIN 6537
Overall length L	103 mm
recommended maximum drilling depth L_2	48.3 mm
Series	Diabolo
Coating	TiAlN

Data sheet

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 _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
Uni	suitable		

Data sheet

wet maximum	suitable
wet minimum	suitable
Air	suitable