

Garant
**Diabolo solid carbide HPC drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7:
8,4mm**

Order data

Order number	122651 8,4
GTIN	4062406064693
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 $L_c = L_2 + 1.5 \times D_c$.

Form HB and HE supplied at the same price as HA.

Form **HB**: order with **No. 122642 / 122652**.

Form **HE**: order with **No. 122641 / 122651 + 129100HE**.

When drilling in hardened steels from 56 HRC, only cool using air!

Technical description

Nominal Ø D_c	8.4 mm
Shank Ø D_s	10 mm
Feed f in steel < 60 HRC	0.12 mm/rev.
recommended maximum drilling depth L_2	48.4 mm
Flute length L_c	61 mm
Overall length L	103 mm
Number of cutting edges Z	2
Tolerance nominal Ø	h7

Standard	DIN 6537
Series	Diabolo
Coating	TiAlN
Tool material	Solid carbide
Version	6×D
Type	H
Point angle	140 degrees
Shank	DIN 6535 HA 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
GG(G)	suitable	70 m/min	K
Uni	suitable		
wet maximum	suitable		

wet minimum	suitable
Air	suitable
Services	

Shank grinding Type HE	129100 HE
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