**Hoffmann Group**

Garant

# GARANT Diabolo solid carbide HPC drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7 (mm or inch): 8,06-X

## Order data

| Order number | 122361 8,06-X |
|---|---|
| GTIN | 4062406076405 |
| 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. 122362 / 122372**.
Form **HE:** order with **No. 122361 / 122371 + 129100HE**. Delivery time: 12 working weeks
Minimum order quantity: 3 pcs
Items made to order for a specific customer:
Cancellation only up to a maximum of 3 working days after receipt of order acknowledgement.
Items cannot be returned. We reserve the right to over-deliver or under-deliver by ±10% (minimum 1 piece).

## Technical description

| Number of cutting edges Z | 2 |
|---|---|
| Flute length $L_c$ | 47 mm |
| Overall length L | 89 mm |
| Tolerance nominal Ø | h7 |
| Feed f in steel < 60 HRC | 0.09 mm/rev. |

| | |
|---|---|
| Shank Ø $D_s$ | 10 mm |
| Standard | DIN 6537 K |
| Ø range | 8.06 - 10.05 mm |
| Series | Diabolo |
| Coating | TiAlN |
| Tool material | Solid carbide |
| Version | 4×D |
| Type | H |
| Point angle | 140 degrees |
| Shank | DIN 6535 HA 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 |

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