Data sheet

GARANT Diabolo solid carbide HPC drill, Weldon shank DIN 6535 HB, TiAlN, ⌀ DC h7: 6,06-Xmm

Order data

Order number	122362 6,06-X
GTIN	4062406076474
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 $L_C = L_2 + 1.5 \times D_C$. 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

Shank ⌀ D_s	8 mm
Tolerance nominal ⌀	h7
Standard	DIN 6537 K
Flute length L_c	34 mm
Feed f in steel < 60 HRC	0.08 mm/rev.
Number of cutting edges Z	2
Overall length L	79 mm

∅ range	6.06 - 7 mm
Series	Diabolo
Coating	TiAlN
Tool material	Solid carbide
Version	4×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/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
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/mm²	suitable only under restricted conditions	28 m/min	H
GG(G)	suitable	70 m/min	K
Uni	suitable		
wet maximum	suitable		
dry	suitable		