

## Garant

### Diabolo solid carbide HPC drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7: 6,06-Xmm



#### Order data

|              |               |
|--------------|---------------|
| Order number | 122641 6,06-X |
| GTIN         | 4062406078461 |
| 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**. 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  $\pm 10\%$  (minimum 1 piece).

#### Technical description

|                             |              |
|-----------------------------|--------------|
| Overall length L            | 91 mm        |
| Tolerance nominal Ø         | h7           |
| Feed f in steel < 60 HRC    | 0.09 mm/rev. |
| Shank Ø D <sub>s</sub>      | 8 mm         |
| Flute length L <sub>c</sub> | 53 mm        |
| Standard                    | DIN 6537     |

|                           |                   |
|---------------------------|-------------------|
| Number of cutting edges Z | 2                 |
| Ø range                   | 6.06 - 8.05 mm    |
| Series                    | Diabolo           |
| Coating                   | TiAlN             |
| Tool material             | Solid carbide     |
| Version                   | 6xD               |
| 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 <sub>c</sub> | ISO code |
|--------------------------------|---|----------------|----------|
| Steel < 500 N/mm <sup>2</sup>  | suitable only under restricted conditions | 90 m/min       | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable only under restricted conditions | 80 m/min       | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable                                  | 70 m/min       | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable                                  | 65 m/min       | P        |
| Steel < 1400 N/mm <sup>2</sup> | 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 |