

## Garant

### Diabolo solid carbide HPC drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7: 18,06-Xmm



#### Order data

Order number	122651 18,06-X
GTIN	4062406078676
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! 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

Feed f in steel < 1100 N/mm <sup>2</sup>	0.35 mm/rev.
Number of cutting edges Z	2
Overall length L	153 mm
Standard	DIN 6537

Flute length $L_c$	101 mm
Tolerance nominal $\varnothing$	h7
Shank $\varnothing D_s$	20 mm
$\varnothing$ range	18.06 - 20.05 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	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 <sup>2</sup>	suitable only under restricted conditions	120 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	100 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	85 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	70 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
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable		
Air	suitable		