

Garant**GARANT Diabolo solid carbide HPC drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 12,06-Xmm****Order data**

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|--------------|----------------|
| Order number | 122642 12,06-X |
| GTIN | 4062406078560 |
| 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 $\pm 10\%$ (minimum 1 piece).

Technical description

| | |
|---------------------------|------------------|
| Tolerance nominal Ø | h7 |
| Flute length L_c | 77 mm |
| Number of cutting edges Z | 2 |
| Standard | DIN 6537 |
| Shank Ø D_s | 14 mm |
| Overall length L | 124 mm |
| Feed f in steel < 60 HRC | 0.13 mm/rev. |
| Ø range | 12.06 - 14.05 mm |

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|--------------------|-------------------|
| Series | Diabolo |
| Coating | TiAlN |
| Tool material | Solid carbide |
| Version | 6×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/mm ² | suitable only under restricted conditions | 90 m/min | P |
| Steel < 750 N/mm ² | suitable only under restricted conditions | 80 m/min | P |
| Steel < 900 N/mm ² | suitable | 70 m/min | P |
| Steel < 1100 N/mm ² | suitable | 65 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 |
| TOOLOX 33 | suitable only under restricted conditions | 30 m/min | H |
| TOOLOX 44 | suitable only under restricted conditions | 28 m/min | H |

Data sheet

| | | | |
|---|--|----------|---|
| HARDOX 500 < 1600 N/ mm ² | suitable only under restricted conditions | 28 m/min | H |
| GG(G) | suitable | 70 m/min | K |
| Uni | suitable | | |
| wet maximum | suitable | | |
| dry | suitable | | |