

**Garant****GARANT Diabolo solid carbide HPC drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 18,06-Xmm****Order data**

|              |                |
|--------------|----------------|
| Order number | 122652 18,06-X |
| GTIN         | 4062406078768  |
| 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**

|  |              |
|--|--------------|
| Overall length L                         | 153 mm       |
| Number of cutting edges Z                | 2            |
| Tolerance nominal Ø                      | h7           |
| Flute length $L_c$                       | 101 mm       |
| Feed f in steel < 1100 N/mm <sup>2</sup> | 0.35 mm/rev. |
| Shank Ø $D_s$                            | 20 mm        |
| Standard                                 | DIN 6537     |

## Data sheet

|                    |                   |
|--------------------|-------------------|
| Ø range            | 18.06 - 20.05 mm  |
| 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    | yes, with 25 bar  |
| 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 | 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        |
| TOOLOX 33                      | suitable                                  | 30 m/min       | H        |
| TOOLOX 44                      | suitable                                  | 28 m/min       | H        |

## Data sheet

|   |          |          |   |
|---|----------|----------|---|
| HARDOX 500 < 1600 N/<br>mm <sup>2</sup> | suitable | 28 m/min | H |
| GG(G)                                   | suitable | 70 m/min | K |
| Uni                                     | suitable |          |   |
| wet maximum                             | suitable |          |   |
| wet minimum                             | suitable |          |   |
| Air                                     | suitable |          |   |