

**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
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
HARDOX 500 < 1600 N/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		