

## Garant

**Diabolo solid carbide HPC drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7 (mm or inch): 12,8 mm or inch**



### Order data

Order number	122371 12,8
GTIN	4062406065577
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.

#### Recommendation:

##### Maximum drilling depth:

flute length (see table) less  $1.5 \times \text{nominal } \varnothing$ .

#### 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. 122362 / 122372**.

Form **HE**: order with **No. 122361 / 122371 + 129100HE**.

Standard: DIN 6537 K

Tolerance nominal  $\varnothing$ : h7

Number of cutting edges Z: 2

Tolerance nominal  $\varnothing$ : h7

recommended maximum drilling depth  $L_2$ : 40.8 mm

Overall length L: 107 mm

Shank  $\varnothing D_s$ : 14 mm

Feed f in steel < 60 HRC: 0.16 mm/rev.

### Technical description

Overall length L	107 mm
Standard	DIN 6537 K

Flute length $L_c$	60 mm
Tolerance nominal $\varnothing$	h7
recommended maximum drilling depth $L_2$	40.8 mm
Feed $f$ in steel < 60 HRC	0.16 mm/rev.
Shank $\varnothing D_s$	14 mm
Nominal $\varnothing D_c$	12.8 mm
Number of cutting edges $Z$	2
Series	Diabolo
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	4xD
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

## Services

Shank grinding Type HE	129100 HE
------------------------	-----------