

Garant
Diabolo solid carbide HPC drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 1/4 mm

Order data

Order number	122372 1/4
GTIN	4062406121556
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 $L_c = L_2 + 1.5 \times D_c$.

Standard: DIN 6537 K

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

Semi-Standard: yes

Tolerance nominal Ø: h7

recommended maximum drilling depth L_2 : 24.475 mm

Overall length L: 79 mm

Shank Ø D_s : 8 mm

Feed f in steel < 1100 N/mm²: 0.2 mm/rev.

Feed f in steel < 60 HRC: 0.08 mm/rev.

Technical description

Inch nominal Ø corresponds to	6.35 mm
Tolerance nominal Ø	h7
Overall length L	79 mm
Number of cutting edges Z	2

Feed f in steel < 1100 N/mm ²	0.2 mm/rev.
recommended maximum drilling depth L ₂	24.475 mm
Feed f in steel < 60 HRC	0.08 mm/rev.
Shank Ø D _s	8 mm
Flute length L _c	34 mm
Standard	DIN 6537 K
Semi-Standard	yes
Series	Diabolo
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	4×D
Type	H
Point angle	140 degrees
Shank	DIN 6535 HB to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Colour ring	red
Type of product	Jobber drill