

Garant

Diabolo solid carbide HPC drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7: 18 mm



Order data

Order number	122641 18
GTIN	4062406088798
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×nominal Ø.

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. 122642 / 122652**.

Form **HE**: order with **No. 122641 / 122651 + 129100HE**.

Standard: DIN 6537

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

Semi-Standard: yes

Tolerance nominal Ø: h7

recommended maximum drilling depth L_2 : 66 mm

Overall length L: 143 mm

Shank Ø D_s : 18 mm

Feed f in steel < 60 HRC: 0.15 mm/rev.

Technical description

Shank Ø D_s	18 mm
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Nominal $\varnothing D_c$	18 mm
Feed f in steel < 60 HRC	0.15 mm/rev.
Overall length L	143 mm
Standard	DIN 6537
Number of cutting edges Z	2
recommended maximum drilling depth L_2	66 mm
Flute length L_c	93 mm
Tolerance nominal \varnothing	h7
Semi-Standard	yes
Series	Diabolo
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	6×D
Type	H
Point angle	140 degrees
Shank	DIN 6535 HA to h6
Through-coolant	no
Machining strategy	HPC
Colour ring	red
Type of product	Jobber drill

Services

Shank grinding Type HE	129100 HE
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