

Garant

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



Order data

Order number	122642 18
GTIN	4062406089160
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 $L_c = L_2 + 1.5 \times D_c$.

Standard: DIN 6537

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

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

recommended maximum drilling depth L_2	66 mm
Flute length L_c	93 mm
Tolerance nominal Ø	h7
Overall length L	143 mm

Standard	DIN 6537
Number of cutting edges Z	2
Nominal $\varnothing D_c$	18 mm
Shank $\varnothing D_s$	18 mm
Feed f in steel < 60 HRC	0.15 mm/rev.
Series	Diabolo
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	6xD
Type	H
Point angle	140 degrees
Shank	DIN 6535 HB to h6
Through-coolant	no
Machining strategy	HPC
Semi-Standard	yes
Colour ring	red
Type of product	Jobber drill