

## Garant

### Diabolo solid carbide HPC drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7: 1,8 mm



#### Order data

Order number	122651 1,8
GTIN	4045197969866
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

Tolerance nominal Ø: h7

recommended maximum drilling depth  $L_2$ : 13.3 mm

Overall length L: 55 mm

Shank Ø  $D_s$ : 4 mm

Feed f in steel < 60 HRC: 0.013 mm/rev.

#### Technical description

Number of cutting edges Z	2
Feed f in steel < 60 HRC	0.013 mm/rev.

Flute length $L_c$	16 mm
Shank $\varnothing D_s$	4 mm
Nominal $\varnothing D_c$	1.8 mm
recommended maximum drilling depth $L_2$	13.3 mm
Tolerance nominal $\varnothing$	h7
Overall length L	55 mm
Standard	DIN 6537
Series	Diabolo
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	6xD
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