

## Garant

### Diabolo solid carbide HPC drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7: 7,7 mm



#### Order data

|              |               |
|--------------|---------------|
| Order number | 122651 7,7    |
| GTIN         | 4062406064655 |
| 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  $L_2$ : 41.5 mm

Overall length L: 91 mm

Shank Ø  $D_s$ : 8 mm

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

#### Technical description

|                 |        |
|-----------------|--------|
| Nominal Ø $D_c$ | 7.7 mm |
|-----------------|--------|

|  |                   |
|--|-------------------|
| Tolerance nominal $\varnothing$          | h7                |
| Standard                                 | DIN 6537          |
| Flute length $L_c$                       | 53 mm             |
| Feed f in steel < 60 HRC                 | 0.08 mm/rev.      |
| recommended maximum drilling depth $L_2$ | 41.5 mm           |
| Shank $\varnothing D_s$                  | 8 mm              |
| Number of cutting edges Z                | 2                 |
| Overall length L                         | 91 mm             |
| 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                          | yes, with 25 bar  |
| Machining strategy                       | HPC               |
| Colour ring                              | red               |
| Type of product                          | Jobber drill      |

## Services

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