

## Garant

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



#### Order data

|              |               |
|--------------|---------------|
| Order number | 122652 4,4    |
| GTIN         | 4062406089177 |
| 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  $L_2$ : 29.4 mm

Overall length L: 74 mm

Shank Ø  $D_s$ : 6 mm

Feed f in steel < 60 HRC: 0.04 mm/rev.

#### Technical description

|                    |          |
|--------------------|----------|
| Nominal Ø $D_c$    | 4.4 mm   |
| Standard           | DIN 6537 |
| Overall length L   | 74 mm    |
| Flute length $L_c$ | 36 mm    |

|   |                   |
|---|-------------------|
| Feed f in steel < 60 HRC                          | 0.04 mm/rev.      |
| Number of cutting edges Z                         | 2                 |
| recommended maximum drilling depth L <sub>2</sub> | 29.4 mm           |
| Tolerance nominal Ø                               | h7                |
| Shank Ø D <sub>s</sub>                            | 6 mm              |
| Series  | Diabolo           |
| Coating   | TiAlN             |
| Tool material                                     | Solid carbide     |
| Drill depth up to                                 | 6×D               |
| Type  | H                 |
| Point angle                                       | 140 degrees       |
| Shank   | DIN 6535 HB to h6 |
| Through-coolant                                   | yes, with 25 bar  |
| Machining strategy                                | HPC               |
| Semi-Standard                                     | yes               |
| Colour ring                                       | red               |
| Type of product                                   | Jobber drill      |