

## Garant

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



#### Order data

Order number	122652 7,7
GTIN	4062406089214
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  $L_2$ : 41.45 mm

Overall length L: 91 mm

Shank Ø  $D_s$ : 8 mm

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

#### Technical description

Overall length L	91 mm
Standard	DIN 6537
Tolerance nominal Ø	h7
Flute length $L_c$	53 mm

recommended maximum drilling depth $L_2$	41.45 mm
Nominal $\varnothing D_c$	7.7 mm
Number of cutting edges Z	2
Feed f in steel < 60 HRC	0.08 mm/rev.
Shank $\varnothing D_s$	8 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