

## Garant

**Diabolo solid carbide HPC drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7 (mm or inch): 1,9 mm or inch**



### Order data

Order number	122371 1,9
GTIN	4045197968876
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  $1.5 \times \text{nominal } \varnothing$ .

#### 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. 122362 / 122372**.

Form **HE**: order with **No. 122361 / 122371 + 129100HE**.

Standard: DIN 6537 K

Tolerance nominal  $\varnothing$ : h7

Number of cutting edges Z: 2

Tolerance nominal  $\varnothing$ : h7

recommended maximum drilling depth  $L_2$ : 11.2 mm

Overall length L: 55 mm

Shank  $\varnothing D_s$ : 4 mm

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

### Technical description

Flute length $L_c$	14 mm
Standard	DIN 6537 K

Shank $\varnothing D_s$	4 mm
Overall length L	55 mm
Nominal $\varnothing D_c$	1.9 mm
Tolerance nominal $\varnothing$	h7
Feed f in steel < 60 HRC	0.013 mm/rev.
recommended maximum drilling depth $L_2$	11.2 mm
Number of cutting edges Z	2
Series	Diabolo
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	4xD
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