

Garant

Diabolo solid carbide HPC drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 8,5 mm



Order data

Order number	122372 8,5
GTIN	4045197971623
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.

Note:

Flute length $L_c = L_2 + 1.5 \times D_c$.

Standard: DIN 6537 K

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

Tolerance nominal Ø: h7

recommended maximum drilling depth L_2 : 34.3 mm

Overall length L: 89 mm

Shank Ø D_s : 10 mm

Feed f in steel < 1100 N/mm²: 0.2 mm/rev.

Feed f in steel < 60 HRC: 0.12 mm/rev.

Technical description

Overall length L	89 mm
Nominal Ø D_c	8.5 mm
Flute length L_c	47 mm
recommended maximum drilling depth L_2	34.3 mm
Number of cutting edges Z	2

Standard	DIN 6537 K
Tolerance nominal Ø	h7
Feed f in steel < 1100 N/mm ²	0.2 mm/rev.
Shank Ø D _s	10 mm
Feed f in steel < 60 HRC	0.12 mm/rev.
Series	Diabolo
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	4×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