

## Garant

### Diabolo solid carbide HPC drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 4,2 mm



#### Order data

Order number	122642 4,2
GTIN	4045197971807
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  $L_2$ : 29.7 mm

Overall length L: 74 mm

Shank Ø  $D_s$ : 6 mm

Feed f in steel < 60 HRC: 0.07 mm/rev.

#### Technical description

Nominal Ø $D_c$	4.2 mm
Overall length L	74 mm
Standard	DIN 6537
Flute length $L_c$	36 mm

Number of cutting edges Z	2
recommended maximum drilling depth L <sub>2</sub>	29.7 mm
Shank Ø D <sub>s</sub>	6 mm
Tolerance nominal Ø	h7
Feed f in steel < 60 HRC	0.07 mm/rev.
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	no
Machining strategy	HPC
Semi-Standard	yes
Colour ring	red
Type of product	Jobber drill