

Garant

Diabolo solid carbide HPC drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7: 1,9 mm



Order data

Order number	122651 1,9
GTIN	4045197969873
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 $L_c = L_2 + 1.5 \times D_c$.

Form HB and HE supplied at the same price as HA.

Form **HB**: order with **No. 122642 / 122652**.

Form **HE**: order with **No. 122641 / 122651 + 129100HE**.

Standard: DIN 6537

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

Tolerance nominal Ø: h7

recommended maximum drilling depth L_2 : 13.2 mm

Overall length L: 55 mm

Shank Ø D_s : 4 mm

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

Technical description

Number of cutting edges Z	2
Standard	DIN 6537

Nominal $\varnothing D_c$	1.9 mm
Shank $\varnothing D_s$	4 mm
Overall length L	55 mm
Flute length L_c	16 mm
Tolerance nominal \varnothing	h7
Feed f in steel < 60 HRC	0.013 mm/rev.
recommended maximum drilling depth L_2	13.2 mm
Series	Diabolo
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	6xD
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