

## Garant

### Diabolo solid carbide HPC drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7: 3,2 mm



#### Order data

|              |               |
|--------------|---------------|
| Order number | 122651 3,2    |
| GTIN         | 4045197969996 |
| 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  $L_2$ : 23.2 mm

Overall length L: 66 mm

Shank Ø  $D_s$ : 6 mm

Feed f in steel < 60 HRC: 0.03 mm/rev.

#### Technical description

|  |         |
|--|---------|
| Overall length L                         | 66 mm   |
| recommended maximum drilling depth $L_2$ | 23.2 mm |

|                                 |                   |
|---------------------------------|-------------------|
| Nominal $\varnothing D_c$       | 3.2 mm            |
| Standard                        | DIN 6537          |
| Tolerance nominal $\varnothing$ | h7                |
| Shank $\varnothing D_s$         | 6 mm              |
| Feed f in steel < 60 HRC        | 0.03 mm/rev.      |
| Number of cutting edges Z       | 2                 |
| Flute length $L_c$              | 28 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      |

## Services

|                        |           |
|------------------------|-----------|
| Shank grinding Type HE | 129100 HE |
|------------------------|-----------|