

## Garant

### Diabolo solid carbide HPC drill, plain shank DIN 6535 HA, TiAlN, Ø DC h7: 9,8 mm



#### Order data

Order number	122651 9,8
GTIN	4045197970442
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

Semi-Standard: yes

Tolerance nominal Ø: h7

recommended maximum drilling depth  $L_2$ : 46.3 mm

Overall length L: 103 mm

Shank Ø  $D_s$ : 10 mm

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

#### Technical description

Standard	DIN 6537
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Nominal $\varnothing D_c$	9.8 mm
Shank $\varnothing D_s$	10 mm
Flute length $L_c$	61 mm
recommended maximum drilling depth $L_2$	46.3 mm
Overall length $L$	103 mm
Number of cutting edges $Z$	2
Tolerance nominal $\varnothing$	h7
Feed $f$ in steel < 60 HRC	0.12 mm/rev.
Semi-Standard	yes
Series	Diabolo
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	6×D
Type	H
Point angle	140 degrees
Shank	DIN 6535 HA to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Colour ring	red
Type of product	Jobber drill

## Services

Shank grinding Type HE	129100 HE
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