

## Garant

### Diabolo solid carbide HPC drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 12 mm



#### Order data

Order number	122652 12
GTIN	4045197972729
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  $L_2$ : 53 mm

Overall length L: 118 mm

Shank Ø  $D_s$ : 12 mm

Feed f in steel < 1100 N/mm<sup>2</sup>: 0.32 mm/rev.

#### Technical description

Overall length L	118 mm
Shank Ø $D_s$	12 mm
recommended maximum drilling depth $L_2$	53 mm
Standard	DIN 6537

Nominal $\varnothing D_c$	12 mm
Tolerance nominal $\varnothing$	h7
Flute length $L_c$	71 mm
Feed f in steel < 1100 N/mm <sup>2</sup>	0.32 mm/rev.
Number of cutting edges Z	2
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	yes, with 25 bar
Machining strategy	HPC
Semi-Standard	yes
Colour ring	red
Type of product	Jobber drill