

Garant
Solid carbide micro slot drill, DLC, Ø DC × L1: 1,8X15 mm

Order data

Order number	201140 1,8X15
GTIN	4045197913166
Item class	11X

Description
Version:

With **advanced DLC sp² coating**. For the **highest demands regarding performance and precision in aluminium materials**. **Extremely tight tolerances** ensure maximum accuracy. Double relief ground with 2 hollow-ground chamfers. **Recess angle $\alpha = 16^\circ$** .

Tolerances:

· **Neck Ø: $D_1 = 0 / -0.01$ mm.**

Note:

At greater tool overhang lengths, use a reduced value for a_p !
 Values for:
 slots milled from solid: $a_p = 0.25 \times D \times a_{p,corr}$
 side milling: $a_p = 0.5 \times D \times a_{p,corr}$
To calculate the feed rate vf please use the actual speed of the machine (the maximum possible speed)!
 e.g: $vf = 18000 \text{ [rpm]} \times fz \text{ [mm/Z]} \times z$

Through-coolant: no

Tolerance nominal Ø: $0 / -0.005$

No. of teeth Z: 2

Helix angle: 30 degrees

Direction of infeed: horizontal, oblique and vertical

Shank: DIN 6535 HA to h5

No. of teeth Z: 2

Flute length L_c : 2.7 mm

Overhang length L_1 incl. recess: 15 mm

Recess Ø D_1 : 1.71 mm

Overall length L: 50 mm

Shank Ø D_s : 4 mm

Technical description

Overall length L	50 mm
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Direction of infeed	horizontal, oblique and vertical
Shank	DIN 6535 HA to h5
Overhang length L_1 incl. recess	15 mm
Feed f_z for side milling in cast aluminium	0.035 mm
Recess $\varnothing D_1$	1.71 mm
Flute length L_c	2.7 mm
Feed f_z for slot milling in cast aluminium	0.03 mm
Tolerance nominal \varnothing	0 / -0.005
Cutting edge $\varnothing D_c$	1.8 mm
No. of teeth Z	2
Shank $\varnothing D_s$	4 mm
Helix angle	30 degrees
Correction factor $a_{p\ corr}$	0.8
Corner chamfer angle	90 degrees
Coating	DLC
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	W
Cutting width a_e for milling operation	0.5×D for side milling
Cutting width a_e for milling operation	Full slot cutting depth 1×D
Through-coolant	no
Colour ring	yellow
Type of product	End mill