

Garant
Solid carbide micro slot drill, DLC, Ø DC × L1: 1,5X16 mm

Order data

Order number	201140 1,5X16
GTIN	4062406089818
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 α = 16°**.

Tolerances:

· **Neck Ø: D₁ = 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×D×a_{p corr}
side milling: a_p = 0.5×D×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 [rpm]× fz [mm/Z]× 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: 2.3 mm

Overhang length L₁ incl. recess: 16 mm

Recess Ø D₁: 1.44 mm

Overall length L: 50 mm

Shank Ø D_s: 4 mm

Technical description

Cutting edge Ø D _c	1.5 mm
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Overall length L	50 mm
Flute length L_c	2.3 mm
Tolerance nominal $\varnothing$	0 / -0.005
Correction factor $a_{p\ corr}$	0.4
Direction of infeed	horizontal, oblique and vertical
Feed f_z for side milling in cast aluminium	0.025 mm
Shank $\varnothing D_s$	4 mm
Feed f_z for slot milling in cast aluminium	0.02 mm
Shank	DIN 6535 HA to h5
Recess $\varnothing D_1$	1.44 mm
Helix angle	30 degrees
Overhang length L_1 incl. recess	16 mm
No. of teeth Z	2
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