

Garant
Solid carbide micro slot drill, DLC, Ø Dc xL4: 1,8X6 mm

Order data

Order number	201140 1,8X6
GTIN	4062406089474
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: D₄ = 0 / -0.01 mm.**

Note:

At greater tool overhang lengths, use a reduced value for a_p!

Values for:

slots milled from solid: $a_p = 0.25 \times D \times a_{p \text{ korr}}$

side milling: $a_p = 0.5 \times D \times a_{p \text{ korr}}$

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 L₁ incl. recess: 6 mm

Recess Ø D₁: 1.71 mm

Overall length L: 45 mm

Shank Ø D_s: 4 mm

Technical description

Tolerance nominal $\varnothing$	0 / -0.005
Flute length L_c	2.7 mm
Helix angle	30 degrees
No. of teeth Z	2
Shank	DIN 6535 HA to h5
Direction of infeed	horizontal, oblique and vertical
Overall length L	45 mm
Shank $\varnothing D_s$	4 mm
Feed f_z for side milling in cast aluminium	0.035 mm
Feed f_z for slot milling in cast aluminium	0.03 mm
Recess $\varnothing D_1$	1.71 mm
Correction factor $a_{p\text{ korr}}$	1
Cutting edge $\varnothing D_c$	1.8 mm
Overhang length L_1 incl. recess	6 mm
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