

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

**Order data**

Order number	201140 1X15
GTIN	4045197912916
Item class	11X

**Description**
**Version:**

With **advanced DLC sp<sup>2</sup> 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  $L_c$ : 1.5 mm

Overhang length  $L_1$  incl. recess: 15 mm

Recess Ø  $D_1$ : 0.95 mm

Overall length L: 50 mm

Shank Ø  $D_s$ : 4 mm

**Technical description**

Overhang length $L_1$ incl. recess	15 mm
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Flute length $L_c$	1.5 mm
Feed $f_z$ for slot milling in cast aluminium	0.02 mm
Cutting edge $\varnothing D_c$	1 mm
Recess $\varnothing D_1$	0.95 mm
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 6535 HA to h5
Shank $\varnothing D_s$	4 mm
Tolerance nominal $\varnothing$	0 / -0.005
No. of teeth Z	2
Overall length L	50 mm
Feed $f_z$ for side milling in cast aluminium	0.025 mm
Helix angle	30 degrees
Correction factor $a_{p,corr}$	0.2
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