Garant

Solid carbide micro slot drill, DLC, ⌀ DC × L1: 2X14 mm



Order data

Order number	201140 2X14
GTIN	4062406089825
Item class	11X

Description

Version:
With **advanced DLC sp^2 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 ⌀: 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×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 ⌀: 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: 3 mm
Overhang length L_1 incl. recess: 14 mm
Recess ⌀ D_1: 1.91 mm
Overall length L: 50 mm
Shank ⌀ D_s: 4 mm

Technical description

Correction factor $a_{p\ corr}$	0.8

Tolerance nominal ∅	0 / –0.005
Shank ∅ D_s	4 mm
No. of teeth Z	2
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 6535 HA to h5
Feed f_z for side milling in cast aluminium	0.035 mm
Helix angle	30 degrees
Feed f_z for slot milling in cast aluminium	0.03 mm
Overhang length L_1 incl. recess	14 mm
Flute length L_c	3 mm
Overall length L	50 mm
Recess ∅ D_1	1.91 mm
Cutting edge ∅ D_C	2 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