

Garant
Solid carbide micro slot drill, DLC, Ø Dc×L1: 0,5X6 mm


Order data

Order number	201141 0,5X6
GTIN	4062406387044
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: D₁ = 0 / -0.01 mm.**

Extra-sturdy shank to reduce the tendency to vibrate.

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: 25 degrees

Direction of infeed: horizontal, oblique and vertical

Shank: DIN 6535 HA to h5

No. of teeth Z: 2

Flute length L_c: 0.7 mm

Overhang length L₁ incl. recess: 6 mm

Recess Ø D₁: 0.48 mm

Overall length L: 55 mm

Shank Ø D_s: 6 mm

Technical description

Direction of infeed	horizontal, oblique and vertical
Cutting edge $\varnothing D_c$	0.5 mm
Shank	DIN 6535 HA to h5
Feed f_z for side milling in cast aluminium	0.016 mm
Tolerance nominal \varnothing	0 / -0.005
No. of teeth Z	2
Corner chamfer angle	90 degrees
Flute length L_c	0.7 mm
Shank $\varnothing D_s$	6 mm
Recess $\varnothing D_1$	0.48 mm
Overall length L	55 mm
Helix angle	25 degrees
Overhang length L_1 incl. recess	6 mm
Feed f_z for slot milling in cast aluminium	0.012 mm
Correction factor $a_{p\ corr}$	0.35
Coating	DLC
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	W
Cutting width a_e for milling operation	Full slot cutting depth $1 \times D$
Cutting width a_e for milling operation	$0.5 \times D$ for side milling
Through-coolant	no
Colour ring	yellow
Type of product	End mill