Garant

Solid carbide micro slot drill, DLC, Ø Dc×L1: 0,8X2 mm

Order data

Order number	201141 0,8X2
GTIN	4062406387075
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 Ø: D$_1$ = 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$_c$: 1.2 mm
Overhang length L$_1$ incl. recess: 2 mm
Recess Ø D$_1$: 0.78 mm
Overall length L: 55 mm
Shank Ø D$_s$: 6 mm

Technical description

Helix angle	25 degrees
No. of teeth Z	2
Direction of infeed	horizontal, oblique and vertical
Cutting edge $\varnothing$ D_c	0.8 mm
Feed f_z for side milling in cast aluminium	0.022 mm
Tolerance nominal $\varnothing$	0 / −0.005
Feed f_z for slot milling in cast aluminium	0.018 mm
Shank	DIN 6535 HA to h5
Shank $\varnothing$ D_s	6 mm
Overhang length L_1 incl. recess	2 mm
Overall length L	55 mm
Recess $\varnothing$ D_1	0.78 mm
Correction factor $a_{p\,corr}$	1
Flute length L_c	1.2 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	Full slot cutting depth 1×D
Cutting width a_e for milling operation	0.5×D for side milling
Through-coolant	no
Colour ring	yellow
Type of product	End mill