Garant

Solid carbide micro slot drill, DLC, ∅ Dc×L1: 1,5X10 mm

Order data

Order number	201141 1,5X10
GTIN	4062406387327
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.**
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: $a_p = 0.25 \times D \times a_{p\,corr}$
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 [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: 2.3 mm
Overhang length L_1 incl. recess: 10 mm
Recess ∅ D_1: 1.44 mm
Overall length L: 55 mm
Shank ∅ D_s: 6 mm

Technical description

Helix angle	30 degrees
Overhang length L_1 incl. recess	10 mm
Feed f_z for side milling in cast aluminium	0.033 mm
Overall length L	55 mm
No. of teeth Z	2
Feed f_z for slot milling in cast aluminium	0.03 mm
Cutting edge ∅ D_C	1.5 mm
Recess ∅ D_1	1.44 mm
Tolerance nominal ∅	0 / –0.005
Shank	DIN 6535 HA to h5
Flute length L_c	2.3 mm
Correction factor $a_{p\,corr}$	0.9
Shank ∅ D_s	6 mm
Direction of infeed	horizontal, oblique and vertical
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