

Garant
Solid carbide micro slot drill, DLC, Ø Dc×L1: 1X4 mm

Order data

Order number	201141 1X4
GTIN	4062406387228
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: $D_1 = 0 / -0.01$ 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: $a_p = 0.25 \times D \times a_{p\text{ corr}}$
side milling: $a_p = 0.5 \times D \times a_{p\text{ corr}}$
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: 4 mm

Recess Ø D_1 : 0.95 mm

Overall length L: 55 mm

Shank Ø D_s : 6 mm

Technical description

Feed f_z for side milling in cast aluminium	0.033 mm
Tolerance nominal \varnothing	0 / -0.005
Direction of infeed	horizontal, oblique and vertical
Flute length L_c	1.5 mm
Helix angle	30 degrees
Feed f_z for slot milling in cast aluminium	0.03 mm
No. of teeth Z	2
Correction factor $a_{p\text{ corr}}$	1
Shank	DIN 6535 HA to h5
Overall length L	55 mm
Shank $\varnothing D_s$	6 mm
Corner chamfer angle	90 degrees
Recess $\varnothing D_1$	0.95 mm
Cutting edge $\varnothing D_c$	1 mm
Overhang length L_1 incl. recess	4 mm
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