Garant

Diabolo solid carbide micro slot drill, TiAlN, ⌀ DC × L1: 0,1X0,5 mm

Order data

Order number	201631 0,1X0,5
GTIN	4045197932303
Item class	11X

Description

Version:
GARANT Diabolo:
Special geometry, coating and carbide **for hard machining in the high-performance field.** Suitable even for **machining electrolytic copper.** Double-relief ground 2 chamfers hollow ground for high-precision hard machining.
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: $a_p = 0.05 \times D \times a_p$ korr
side milling: $a_p = 0.1 \times D \times a_p$ korr
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: 25 degrees
Direction of infeed: horizontal, oblique and vertical
Shank: DIN 6535 HA to h5
No. of teeth Z: 2
Flute length L_c: 0.15 mm
Overhang length L_1 incl. recess: 0.5 mm
Recess ⌀ D_1: 0.08 mm
Overall length L: 45 mm
Shank ⌀ D_s: 4 mm

Technical description

Overhang length L_1 incl. recess	0.5 mm
Correction factor $a_{p\,corr}$	1
No. of teeth Z	2
Direction of infeed	horizontal, oblique and vertical
Feed f_z for slot milling in steel < 65 HRC	0.005 mm
Helix angle	25 degrees
Tolerance nominal ∅	0 / –0,005
Recess ∅ D_1	0.08 mm
Cutting edge ∅ D_C	0.1 mm
Overall length L	45 mm
Shank ∅ D_s	4 mm
Shank	DIN 6535 HA to h5
Flute length L_c	0.15 mm
Feed f_z for side milling in steel < 65 HRC	0.009 mm
Corner chamfer angle	90 degrees
Series	Diabolo
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	H
Cutting width a_e for milling operation	Full slot cutting depth 1×D
Cutting width a_e for milling operation	0.1×D for side milling
Through-coolant	no
Colour ring	red
Type of product	End mill