

**Garant**
**Diabolo solid carbide micro slot drill, TiAlN, Ø DC × L1: 0,7X6 mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 201631 0,7X6  |
| GTIN         | 4062406187484 |
| 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  $\alpha = 16^\circ$ .

Tolerances:

· **Neck Ø:  $D_1 = 0 / -0.01$  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

No. of teeth Z: 2

Helix angle: 25 degrees

Shank: DIN 6535 HA to h5

No. of teeth Z: 2

Flute length  $L_c$ : 1 mm

Overhang length  $L_1$  incl. recess: 6 mm

Overall length L: 45 mm

Shank Ø  $D_s$ : 4 mm

**Technical description**

|                      |        |
|----------------------|--------|
| Cutting edge Ø $D_c$ | 0.7 mm |
|----------------------|--------|

|   |                                      |
|---|--------------------------------------|
| No. of teeth Z                            | 2                                    |
| Helix angle                               | 25 degrees                           |
| Shank                                     | DIN 6535 HA to h5                    |
| Flute length $L_c$                        | 1 mm                                 |
| Overhang length $L_1$ incl. recess        | 6 mm                                 |
| Overall length L                          | 45 mm                                |
| Shank $\varnothing D_s$                   | 4 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 $1 \times D$ |
| Cutting width $a_e$ for milling operation | $0.1 \times D$ for side milling      |
| Through-coolant                           | no                                   |
| Colour ring                               | red                                  |
| Type of product                           | End mill                             |