

Garant
Diabolo solid carbide micro slot drill, TiAlN, Ø DC × L1: 0,8X24 mm

Order data

Order number	201631 0,8X24
GTIN	4062406187521
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 : 1.2 mm

Overhang length L_1 incl. recess: 24 mm

Overall length L: 70 mm

Shank Ø D_s : 4 mm

Technical description

Overhang length L_1 incl. recess	24 mm
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Shank	DIN 6535 HA to h5
Shank $\varnothing D_s$	4 mm
No. of teeth Z	2
Overall length L	70 mm
Cutting edge $\varnothing D_c$	0.8 mm
Flute length L_c	1.2 mm
Helix angle	25 degrees
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