

**Garant**
**Diabolo solid carbide micro slot drill, TiAlN, Ø DC×L1: 1,4X22 mm**

**Order data**

Order number	201631 1,4X22
GTIN	4062406187606
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]  $\times$   $fz$  [mm/Z]  $\times$   $z$**

Through-coolant: no

No. of teeth Z: 2

Helix angle: 30 degrees

Shank: DIN 6535 HA to h5

No. of teeth Z: 2

Shank Ø  $D_s$ : 4 mm

**Technical description**

No. of teeth Z	2
Helix angle	30 degrees
Shank Ø $D_s$	4 mm

Shank	DIN 6535 HA to h5
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