Garant

# Diabolo solid carbide micro slot drill, TiAlN, ⌀ DC×L1: 1X25 mm



## Order data

| | |
|---|---|
| Order number | 201631 1X25 |
| GTIN | 4062406187552 |
| 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
No. of teeth Z: 2
Helix angle: 30 degrees
Shank: DIN 6535 HA to h5
No. of teeth Z: 2
Shank ⌀ $D_s$: 4 mm

## Technical description

| | |
|---|---|
| Shank | DIN 6535 HA to h5 |
| Helix angle | 30 degrees |
| No. of teeth Z | 2 |

| | |
|---|---|
| Shank ∅ $D_s$ | 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×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 |