

Garant
Diabolo solid carbide micro slot drill, TiAlN, Ø DC×L1: 0,8X4 mm

Order data

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|--------------|---------------|
| Order number | 201632 0,8X4 |
| GTIN | 4062406386436 |
| 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 $\alpha = 16^\circ$.

Extra sturdy shank for achieving longer tool life.

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

Tolerance nominal Ø: $0 / -0,005$

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 : 1.2 mm

Overhang length L_1 incl. recess: 4 mm

Recess Ø D_1 : 0.78 mm

Overall length L: 54 mm

Shank Ø D_s : 6 mm

Technical description

| | |
|---|--------------------------------------|
| Overall length L | 54 mm |
| Direction of infeed | horizontal, oblique and vertical |
| Tolerance nominal \varnothing | 0 / -0,005 |
| Shank | DIN 6535 HA to h5 |
| Flute length L_c | 1.2 mm |
| Corner chamfer angle | 90 degrees |
| Feed f_z for side milling in steel < 65 HRC | 0.017 mm |
| Recess $\varnothing D_1$ | 0.78 mm |
| Overhang length L_1 incl. recess | 4 mm |
| Helix angle | 25 degrees |
| No. of teeth Z | 2 |
| Cutting speed v_c in steel < 65 HRC | 55 m/min |
| Feed f_z for slot milling in steel < 65 HRC | 0.014 mm |
| Shank $\varnothing D_s$ | 6 mm |
| Correction factor $a_{p,corr}$ | 1 |
| Cutting edge $\varnothing D_c$ | 0.8 mm |
| 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 |

