Garant

Diabolo solid carbide micro slot drill, TiAlN, Ø DC×L1: 3X12 mm

Order data

Order number	201632 3X12
GTIN	4062406386788
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°.
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]× fz [mm/Z]× z
Through-coolant: no
Tolerance nominal Ø: 0 / –0,005
No. of teeth Z: 2
Helix angle: 30 degrees
Direction of infeed: horizontal, oblique and vertical
Shank: DIN 6535 HA to h5
No. of teeth Z: 2
Flute length L_c: 4.6 mm
Overhang length L_1 incl. recess: 12 mm
Recess Ø D_1: 2.91 mm
Overall length L: 54 mm
Shank Ø D_s: 6 mm

Technical description

No. of teeth Z	2
Shank ∅ D_s	6 mm
Direction of infeed	horizontal, oblique and vertical
Correction factor $a_{p\,corr}$	1
Cutting edge ∅ D_C	3 mm
Overhang length L_1 incl. recess	12 mm
Helix angle	30 degrees
Cutting speed v_c in steel < 65 HRC	50 m/min
Recess ∅ D_1	2.91 mm
Tolerance nominal ∅	0 / –0,005
Feed f_z for side milling in steel < 65 HRC	0.033 mm
Overall length L	54 mm
Feed f_z for slot milling in steel < 65 HRC	0.027 mm
Flute length L_c	4.6 mm
Corner chamfer angle	90 degrees
Shank	DIN 6535 HA to h5
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