

**Garant**
**Diabolo solid carbide copy slot drill, TiAlN,  $\varnothing$  Dc x L1: 0,6X2 mm**


## Order data

|              |               |
|--------------|---------------|
| Order number | 207377 0,6X2  |
| GTIN         | 4062406387686 |
| 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.**

Recess angle  $\alpha = 16^\circ$ .

Extra-sturdy shank for achieving longer tool life.

Tolerances:

- **Corner radius: Radius contour = 0 / -0.005 mm.**
- **Neck  $\varnothing$ :  $D_1 = 0 / -0.01$  mm.**

### Note:

At greater tool overhang lengths, use a reduced value for  $a_p$ !  
values for:

copying:  $a_p = 0.05 \times D \times a_{p, \text{korr}}$

**To calculate the feed rate  $vf$  please use the actual speed of the machine (the maximum possible speed)! e.g:  $vf = 18000 \text{ [rpm]} \times fz \text{ [mm/Z]} \times z$**

No. of teeth Z: 2

Helix angle: 25 degrees

No. of teeth Z: 2

Flute length  $L_c$ : 0.48 mm

Corner radius  $R_1$ : 0.3 mm

Overhang length  $L_1$  incl. recess: 2 mm

Recess  $\varnothing$   $D_1$ : 0.57 mm

Overall length L: 54 mm

## Technical description

|   |          |
|---|----------|
| Feed $f_z$ for copy milling in steel < 65 HRC | 0.018 mm |
|---|----------|

|   |                                  |
|---|----------------------------------|
| Shank $\varnothing D_s$                   | 6 mm                             |
| Corner radius $R_1$                       | 0.3 mm                           |
| Cutting edge $\varnothing D_c$            | 0.6 mm                           |
| Flute length $L_c$                        | 0.48 mm                          |
| Overhang length $L_1$ incl. recess        | 2 mm                             |
| Overall length $L$                        | 54 mm                            |
| Helix angle                               | 25 degrees                       |
| Recess $\varnothing D_1$                  | 0.57 mm                          |
| Correction factor $a_{p\ corr}$           | 1                                |
| No. of teeth $Z$                          | 2                                |
| Series                                    | Diabolo                          |
| Coating                                   | TiAlN                            |
| Tool material                             | Solid carbide                    |
| Standard                                  | Manufacturer's standard          |
| Type                                      | H                                |
| Tolerance nominal $\varnothing$           | 0 / -0,005                       |
| Direction of infeed                       | horizontal, oblique and vertical |
| Cutting width $a_e$ for milling operation | 0.05×D for copy milling          |
| Shank                                     | DIN 6535 HA to h5                |
| Through-coolant                           | no                               |
| Colour ring                               | red                              |
| Type of product                           | End mill                         |