

**Garant**
**Diabolo solid carbide copy slot drill, TiAlN, Ø Dc × L1: 0,8X8 mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 207377 0,8X8  |
| GTIN         | 4062406387778 |
| 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 Ø: D<sub>1</sub> = 0 / -0.01 mm.**

**Note:**

At greater tool overhang lengths, use a reduced value for a<sub>p</sub>!  
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: 30 degrees

No. of teeth Z: 2

Flute length L<sub>c</sub>: 0.64 mm

Corner radius R<sub>1</sub>: 0.4 mm

Overhang length L<sub>1</sub> incl. recess: 8 mm

Recess Ø D<sub>1</sub>: 0.77 mm

Overall length L: 54 mm

**Technical description**

|                             |         |
|-----------------------------|---------|
| Flute length L <sub>c</sub> | 0.64 mm |
|-----------------------------|---------|

|   |                                  |
|---|----------------------------------|
| Corner radius $R_1$                           | 0.4 mm                           |
| No. of teeth $Z$                              | 2                                |
| Feed $f_z$ for copy milling in steel < 65 HRC | 0.014 mm                         |
| Cutting edge $\varnothing D_c$                | 0.8 mm                           |
| Recess $\varnothing D_1$                      | 0.77 mm                          |
| Helix angle                                   | 30 degrees                       |
| Overall length $L$                            | 54 mm                            |
| Correction factor $a_{p\ corr}$               | 0.5                              |
| Shank $\varnothing D_s$                       | 6 mm                             |
| Overhang length $L_1$ incl. recess            | 8 mm                             |
| 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                         |