

Garant
Diabolo solid carbide copy slot drill, TiAlN, Ø Dc x L1: 1X8 mm

Order data

Order number	207377 1X8
GTIN	4062406502959
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: D₁ = 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: 30 degrees

No. of teeth Z: 2

Flute length L_c: 0.8 mm

Corner radius R₁: 0.5 mm

Overhang length L₁ incl. recess: 8 mm

Recess Ø D₁: 0.96 mm

Overall length L: 45 mm

Technical description

Feed f _z for copy milling in steel < 65 HRC	0.02 mm
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Flute length L_c	0.8 mm
Shank $\varnothing D_s$	4 mm
Overhang length L_1 incl. recess	8 mm
Correction factor $a_{p\ corr}$	0.8
Overall length L	45 mm
No. of teeth Z	2
Cutting edge $\varnothing D_c$	1 mm
Helix angle	30 degrees
Corner radius R_1	0.5 mm
Recess $\varnothing D_1$	0.96 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