

Garant
Solid carbide slot drill HPC, TiAlN, Ø DC: 1 mm

Order data

Order number	201648 1
GTIN	4045197641427
Item class	11X

Description
Version:
GARANT Diabolo 70:

Special solid carbide substrate with extremely high tensile strength combined with **outstanding wear resistance** for optimum process reliability. Newly developed **nano-crystalline high-tech coating for hard milling up to 70 HRC**. Very suitable for **continuous use** in tool and mould making.

Sizes 0.5 – 5: **Recess angle $\alpha = 15^\circ$** .

Application:

Due to the **special hard geometry** ideal for use on hardened materials from 60 HRC to 70 HRC.

Note:

f_z for $a_p = 0.05 \times D$.

Tolerance nominal \varnothing : 0 / -0.02

No. of teeth Z: 2

Helix angle: 35 degrees

Direction of infeed: horizontal, oblique and vertical

Shank: DIN 6535 HA to h6

No. of teeth Z: 2

Flute length L_c : 2.5 mm

Overall length L: 40 mm

Shank $\varnothing D_s$: 4 mm

Feed f_z for slot milling in steel < 70 HRC: 0.003 mm

Feed f_z for side milling in steel < 70 HRC: 0.004 mm

Technical description

Feed f_z for side milling in steel < 70 HRC	0.004 mm
Cutting edge $\varnothing D_c$	1 mm

No. of teeth Z	2
Feed f_z for slot milling in steel < 70 HRC	0.003 mm
Shank $\varnothing D_s$	4 mm
Overall length L	40 mm
Flute length L_c	2.5 mm
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 6535 HA to h6
Tolerance nominal \varnothing	0 / -0.02
Helix angle	35 degrees
Corner chamfer angle	90 degrees
Series	Diabolo
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	H
Helix angle characteristic	unequal spacing
Cutting width a_e for milling operation	0.05×D for side milling
Cutting width a_e for milling operation	Full slot cutting depth 1×D
Through-coolant	no
Machining strategy	HPC
Colour ring	red
Type of product	End mill