

**Garant**
**Solid carbide slot drill HPC, TiAlN, Ø DC: 4 mm**

**Order data**

Order number	201648 4
GTIN	4045197641472
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  $L_c$ : 10 mm

Overall length L: 50 mm

Shank  $\varnothing D_s$ : 6 mm

Feed  $f_z$  for slot milling in steel < 70 HRC: 0.008 mm

Feed  $f_z$  for side milling in steel < 70 HRC: 0.01 mm

**Technical description**

Cutting edge $\varnothing D_c$	4 mm
No. of teeth Z	2

Feed $f_z$ for side milling in steel < 70 HRC	0.01 mm
Feed $f_z$ for slot milling in steel < 70 HRC	0.008 mm
Shank $\varnothing D_s$	6 mm
Overall length L	50 mm
Flute length $L_c$	10 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

## Services

Shank grinding Type HB

129100 HB