

**Garant**
**Solid carbide copy slot drill, DLC, Ø DC × L1: 1,5X15 mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 207023 1,5X15 |
| GTIN         | 4045197916495 |
| Item class   | 11X           |

**Description**
**Version:**

With **advanced DLC sp<sup>2</sup> coating**. For the **highest demands regarding performance and precision in aluminium materials**. **Extremely tight tolerances** ensure maximum accuracy. Double-relief ground with 2 chamfers hollow ground.

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

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:  $a_p = 0.25 \times D \times a_{p, \text{korr}}$

**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>: 1.2 mm

Corner radius R<sub>1</sub>: 0.75 mm

Overhang length L<sub>1</sub> incl. recess: 15 mm

Recess Ø D<sub>1</sub>: 1.44 mm

Overall length L: 50 mm

**Technical description**

|                |   |
|----------------|---|
| No. of teeth Z | 2 |
|----------------|---|

|   |                                  |
|---|----------------------------------|
| Feed $f_z$ for copy milling in cast aluminium | 0.025 mm                         |
| Overall length L                              | 50 mm                            |
| Cutting edge $\varnothing D_c$                | 1.5 mm                           |
| Shank $\varnothing D_s$                       | 4 mm                             |
| Overhang length $L_1$ incl. recess            | 15 mm                            |
| Flute length $L_c$                            | 1.2 mm                           |
| Recess $\varnothing D_1$                      | 1.44 mm                          |
| Corner radius $R_1$                           | 0.75 mm                          |
| Helix angle                                   | 30 degrees                       |
| Correction factor $a_{p,corr}$                | 0.5                              |
| Coating                                       | DLC                              |
| Tool material                                 | Solid carbide                    |
| Standard                                      | Manufacturer's standard          |
| Type  | W                                |
| 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                                   | yellow                           |
| Type of product                               | End mill                         |