

**Garant**
**Solid carbide copy slot drill, DLC, Ø DC × L1: 1,8X12 mm**

**Order data**

Order number	207023 1,8X12
GTIN	4045197916556
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>: 1.44 mm

Corner radius R<sub>1</sub>: 0.9 mm

Overhang length L<sub>1</sub> incl. recess: 12 mm

Recess Ø D<sub>1</sub>: 1.74 mm

Overall length L: 50 mm

**Technical description**

Shank Ø D <sub>s</sub>	4 mm
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Recess $\varnothing D_1$	1.74 mm
Cutting edge $\varnothing D_c$	1.8 mm
Flute length $L_c$	1.44 mm
Overall length $L$	50 mm
No. of teeth $Z$	2
Feed $f_z$ for copy milling in cast aluminium	0.035 mm
Overhang length $L_1$ incl. recess	12 mm
Corner radius $R_1$	0.9 mm
Helix angle	30 degrees
Correction factor $a_{p,corr}$	0.9
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