

Garant
Solid carbide copy slot drill, DLC, Ø DC × L1: 1,8X15 mm

Order data

Order number	207023 1,8X15
GTIN	4045197916563
Item class	11X

Description
Version:

With **advanced DLC sp² 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: D₁ = 0 / -0.01 mm.**

Note:

At greater tool overhang lengths, use a reduced value for a_p!

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_c: 1.44 mm

Corner radius R₁: 0.9 mm

Overhang length L₁ incl. recess: 15 mm

Recess Ø D₁: 1.74 mm

Overall length L: 50 mm

Technical description

Flute length L _c	1.44 mm
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Overhang length L_1 incl. recess	15 mm
Shank $\varnothing D_s$	4 mm
Feed f_z for copy milling in cast aluminium	0.03 mm
Cutting edge $\varnothing D_c$	1.8 mm
Recess $\varnothing D_1$	1.74 mm
Overall length L	50 mm
No. of teeth Z	2
Corner radius R_1	0.9 mm
Helix angle	30 degrees
Correction factor $a_{p,corr}$	0.8
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