

Garant
Diabolo solid carbide copy slot drill, TiAlN, Ø Dc × L1: 0,4X4 mm

Order data

Order number	207373 0,4X4
GTIN	4045197936011
Item class	11X

Description
Version:
GARANT Diabolo:

Special geometry, coating and carbide **for hard machining in the high-performance field.**
Suitable even for **machining electrolytic copper.**

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: $a_p = 0.05 \times D \times a_{p, \text{korr}}$

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: 25 degrees

No. of teeth Z: 2

Flute length L_c: 0.32 mm

Corner radius R₁: 0.2 mm

Overhang length L₁ incl. recess: 4 mm

Recess Ø D₁: 0.37 mm

Overall length L: 45 mm

Technical description

Correction factor $a_{p, \text{corr}}$	0.5
Overall length L	45 mm

Overhang length L_1 incl. recess	4 mm
Feed f_z for copy milling in steel < 65 HRC	0.009 mm
Recess $\varnothing D_1$	0.37 mm
Helix angle	25 degrees
Shank $\varnothing D_s$	4 mm
Corner radius R_1	0.2 mm
Cutting edge $\varnothing D_c$	0.4 mm
Flute length L_c	0.32 mm
No. of teeth Z	2
Series	Diabolo
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	H
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	red
Type of product	End mill