Garant

Diabolo solid carbide copy slot drill, TiAlN, ⌀ Dc × L1: 0,8X4 mm

Order data

Order number	207373 0,8X4
GTIN	4045197936226
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 α = 16°.
Tolerances:
· **Corner radius: Radius contour = 0 / -0.005 mm.**
· **Neck ⌀: D_1 = 0 / -0.01 mm.**
Note:
At greater tool overhang lengths, use a reduced value for a_p!
values for:
copying: $a_p = 0.05 \times D \times a_{p\,korr}$
To calculate the feed rate vf please use the actual speed of the machine (the maximum possible speed)! e.g: vf = 18000 [rpm]× fz [mm/Z]× z
No. of teeth Z: 2
Helix angle: 30 degrees
No. of teeth Z: 2
Flute length L_c: 0.64 mm
Corner radius R_1: 0.4 mm
Overhang length L_1 incl. recess: 4 mm
Recess ⌀ D_1: 0.77 mm
Overall length L: 45 mm

Technical description

Shank ⌀ D_s	4 mm
Cutting edge ⌀ D_C	0.8 mm

Correction factor $a_{p\,corr}$	1
Overhang length L_1 incl. recess	4 mm
Helix angle	30 degrees
Corner radius R_1	0.4 mm
Flute length L_c	0.64 mm
Recess ⌀ D_1	0.77 mm
Feed f_z for copy milling in steel < 65 HRC	0.015 mm
Overall length L	45 mm
No. of teeth Z	2
Series	Diabolo
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	H
Tolerance nominal ⌀	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