

## Garant

### Diabolo solid carbide copy slot drill, TiAlN, Ø Dc × L1: 1,6X16 mm



## Order data

Order number	207373 1,6X16
GTIN	4045197936639
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: D<sub>1</sub> = 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: 30 degrees

No. of teeth Z: 2

Flute length L<sub>c</sub>: 1.28 mm

Corner radius R<sub>1</sub>: 0.8 mm

Overhang length L<sub>1</sub> incl. recess: 16 mm

Recess Ø D<sub>1</sub>: 1.54 mm

Overall length L: 50 mm

## Technical description

Correction factor $a_{p, \text{corr}}$	0.5
Corner radius R <sub>1</sub>	0.8 mm

Overall length L	50 mm
Flute length L <sub>c</sub>	1.28 mm
Cutting edge Ø D <sub>c</sub>	1.6 mm
No. of teeth Z	2
Shank Ø D <sub>s</sub>	4 mm
Overhang length L <sub>1</sub> incl. recess	16 mm
Helix angle	30 degrees
Feed f <sub>z</sub> for copy milling in steel < 65 HRC	0.025 mm
Recess Ø D <sub>1</sub>	1.54 mm
Series	Diabolo
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	H
Tolerance nominal Ø	0 / -0,005
Direction of infeed	horizontal, oblique and vertical
Cutting width a <sub>e</sub> 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