

Garant
Diabolo solid carbide copy slot drill, TiAlN, Ø Dc × L1: 1,8X12 mm

Order data

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|--------------|---------------|
| Order number | 207373 1,8X12 |
| GTIN | 4045197936660 |
| 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: 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: 12 mm

Recess Ø D₁: 1.74 mm

Overall length L: 45 mm

Technical description

| | |
|--|------------|
| Helix angle | 30 degrees |
| Correction factor a _{p, corr} | 0.9 |

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|---|----------------------------------|
| Recess $\varnothing D_1$ | 1.74 mm |
| Corner radius R_1 | 0.9 mm |
| Cutting edge $\varnothing D_c$ | 1.8 mm |
| Flute length L_c | 1.44 mm |
| Overall length L | 45 mm |
| No. of teeth Z | 2 |
| Overhang length L_1 incl. recess | 12 mm |
| Feed f_z for copy milling in steel < 65 HRC | 0.03 mm |
| Shank $\varnothing D_s$ | 4 mm |
| 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 |