

Garant
Diabolo solid carbide copy slot drill, TiAlN, Ø Dc × L1: 1X25 mm

Order data

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|--------------|---------------|
| Order number | 207373 1X25 |
| GTIN | 4045197936394 |
| 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: 0.8 mm

Corner radius R₁: 0.5 mm

Overhang length L₁ incl. recess: 25 mm

Recess Ø D₁: 0.96 mm

Overall length L: 60 mm

Technical description

| | |
|-------------------------|------------|
| Helix angle | 30 degrees |
| Recess Ø D ₁ | 0.96 mm |

| | |
|---|----------------------------------|
| Correction factor $a_{p\ corr}$ | 0.04 |
| Shank $\varnothing D_s$ | 4 mm |
| Feed f_z for copy milling in steel < 65 HRC | 0.01 mm |
| Cutting edge $\varnothing D_c$ | 1 mm |
| No. of teeth Z | 2 |
| Flute length L_c | 0.8 mm |
| Overall length L | 60 mm |
| Overhang length L_1 incl. recess | 25 mm |
| Corner radius R_1 | 0.5 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 |