

Garant
Diabolo solid carbide copy slot drill, TiAlN, Ø Dc × L1: 1X9 mm

Order data

Order number	207373 1X9
GTIN	4062406188245
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: $D_1 = 0 / -0.01$ mm.**

Note:

At greater tool overhang lengths, use a reduced value for a_p !
values for:

copying: $a_p = 0.05 \times D \times a_{p \text{ kor}}$

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

Overhang length L_1 incl. recess: 9 mm

Recess Ø D_1 : 0.96 mm

Overall length L: 45 mm

Shank Ø D_s : 4 mm

Technical description

Flute length L_c	0.8 mm
Recess Ø D_1	0.96 mm

No. of teeth Z	2
Overall length L	45 mm
Overhang length L ₁ incl. recess	9 mm
Helix angle	30 degrees
Shank Ø D _s	4 mm
Radius R	0.5 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 _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