

**Garant**
**Diabolo solid carbide ball nose slot drill HPC, TiAlN, Ø f8 DC / DS: 2/6 mm**

**Order data**

Order number	207476 2/6
GTIN	4045197600660
Item class	11X

**Description**
**Version:**
**GARANT Diabolo:**

Special geometry, newly developed coating and carbide for hard machining. 4 centre cutting edges to the centre. Therefore can be used as a true **4-edge drill** at all depths of cut.

Tolerance: Radius contour =  $\pm 0.005$  mm.

No. of teeth Z: 4

Helix angle: 30 degrees

No. of teeth Z: 4

Flute length  $L_c$ : 4 mm

Overall length L: 80 mm

Shank  $\varnothing D_s$ : 6 mm

Feed  $f_z$  for side milling in steel < 65 HRC: 0.005 mm

Feed  $f_z$  for copy milling in steel < 65 HRC: 0.005 mm

**Technical description**

Feed $f_z$ for copy milling in steel < 65 HRC	0.005 mm
Cutting edge $\varnothing D_c$	2 mm
No. of teeth Z	4
Feed $f_z$ for side milling in steel < 65 HRC	0.005 mm
Shank $\varnothing D_s$	6 mm
Overall length L	80 mm
Flute length $L_c$	4 mm
Correction factor for $v_c$	1.25

Helix angle	30 degrees
Radius R	1 mm
Series	Diabolo
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	H
Tolerance nominal $\varnothing$	f8
Direction of infeed	horizontal, oblique and vertical
Cutting width $a_e$ for milling operation	0.05×D for copy milling
Cutting width $a_e$ for milling operation	0.2×D for side milling
Shank	DIN 6535 HA to h6
Through-coolant	no
Machining strategy	HPC
Colour ring	red
Type of product	End mill

## Services

Shank grinding Type HB	129100 HB
------------------------	-----------