Garant

Solid carbide micro slot drill, Diamond, ⌀ DC × L1: 0,6X10 mm

Order data

Order number	209700 0,6X10
GTIN	4045197917089
Item class	11Y

Description

Version:
With **crystalline diamond sp^3 coating.** For the **highest demands regarding performance and precision in** fibre-reinforced composites, CRP, GRP, and graphite. **Extremely tight tolerances** ensure maximum accuracy. Double relief ground with 2 hollow-ground chamfers. **Recess angle α = 16°.**
Tolerances:
· **Neck ⌀: D_1 = 0 / -0.01 mm.**
Note:
At greater tool overhang lengths, use a reduced value for a_p!
Values for:
slots milled from solid: $a_p = 0.1 \times D \times a_{p\,korr}$
side milling: $a_p = 0.2 \times D \times a_{p\,korr}$
To calculate the feed rate vf please use the actual speed of the machine (the maximum possible speed)!
e.g: vf = 18000 [rpm]× fz [mm/Z]× z
Through-coolant: no
Tolerance nominal ⌀: 0 / –0.005
No. of teeth Z: 2
Helix angle: 25 degrees
Direction of infeed: horizontal, oblique and vertical
Shank: DIN 6535 HA to h5
No. of teeth Z: 2
Flute length L_c: 0.9 mm
Overhang length L_1 incl. recess: 10 mm
Recess ⌀ D_1: 0.58 mm
Overall length L: 50 mm
Shank ⌀ D_s: 4 mm

Technical description

No. of teeth Z	2
Recess ∅ D_1	0.58 mm
Cutting edge ∅ D_C	0.6 mm
Feed f_z for side milling in graphite	0.016 mm
Shank ∅ D_s	4 mm
Tolerance nominal ∅	0 / –0.005
Overhang length L_1 incl. recess	10 mm
Overall length L	50 mm
Flute length L_c	0.9 mm
Direction of infeed	horizontal, oblique and vertical
Shank	DIN 6535 HA to h5
Feed f_z for slot milling in graphite	0.012 mm
Helix angle	25 degrees
Correction factor $a_{p\,corr}$	0.12
Corner chamfer angle	90 degrees
Coating	Diamond
Tool material	Solid carbide
Standard	Manufacturer's standard
Cutting width a_e for milling operation	0.5×D for side milling
Cutting width a_e for milling operation	Full slot cutting depth 1×D
Through-coolant	no
Colour ring	black
Type of product	End mill