

**Garant**
**Solid carbide micro slot drill, Diamond, Ø DC × L1: 0,8X12 mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 209700 0,8X12 |
| GTIN         | 4062406187132 |
| Item class   | 11Y           |

**Description**
**Version:**

With **crystalline diamond sp<sup>3</sup> 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  $\alpha = 16^\circ$** .

Tolerances:

- **Neck Ø:  $D_1 = 0 / -0.01$  mm.**

**Note:**

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

Values for:

slots milled from solid:  $a_p = 0.1 \times D \times a_{p\text{ korr}}$

side milling:  $a_p = 0.2 \times D \times a_{p\text{ korr}}$

**To calculate the feed rate  $vf$  please use the actual speed of the machine (the maximum possible speed)!**

e.g:  $vf = 18000 \text{ [rpm]} \times fz \text{ [mm/Z]} \times z$

Through-coolant: no

No. of teeth Z: 2

Helix angle: 25 degrees

Shank: DIN 6535 HA to h5

No. of teeth Z: 2

Flute length  $L_c$ : 1.2 mm

Overhang length  $L_1$  incl. recess: 12 mm

Overall length L: 50 mm

Shank Ø  $D_s$ : 4 mm

**Technical description**

|   |                             |
|---|-----------------------------|
| Overhang length $L_1$ incl. recess        | 12 mm                       |
| Flute length $L_c$                        | 1.2 mm                      |
| No. of teeth $Z$                          | 2                           |
| Overall length $L$                        | 50 mm                       |
| Shank                                     | DIN 6535 HA to h5           |
| Helix angle                               | 25 degrees                  |
| Shank $\varnothing D_s$                   | 4 mm                        |
| Cutting edge $\varnothing D_c$            | 0.2 mm                      |
| 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                    |