

**Garant**
**Solid carbide micro slot drill, Diamond, Ø Dc×L1: 1,5X14 mm**

**Order data**

Order number	209700 1,5X14
GTIN	4062406187279
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: 30 degrees

Shank: DIN 6535 HA to h5

No. of teeth Z: 2

Shank Ø  $D_s$ : 4 mm

**Technical description**

Shank	DIN 6535 HA to h5
Shank Ø $D_s$	4 mm

Helix angle	30 degrees
No. of teeth Z	2
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