

**Garant**
**Solid carbide micro slot drill, Diamond, Ø DC × L1: 1X8 mm**

**Order data**

Order number	209700 1X8
GTIN	4045197917188
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:  $vf = 18000$  [rpm] ×  $fz$  [mm/Z] ×  $z$

Through-coolant: no

Tolerance nominal Ø:  $0 / -0.005$

No. of teeth  $Z$ : 2

Helix angle: 30 degrees

Direction of infeed: horizontal, oblique and vertical

Shank: DIN 6535 HA to h5

No. of teeth  $Z$ : 2

Flute length  $L_c$ : 1.5 mm

Overhang length  $L_1$  incl. recess: 8 mm

Recess Ø  $D_1$ : 0.95 mm

Overall length  $L$ : 45 mm

Shank Ø  $D_s$ : 4 mm

## Technical description

Recess $\varnothing D_1$	0.95 mm
Overall length L	45 mm
Overhang length $L_1$ incl. recess	8 mm
No. of teeth Z	2
Feed $f_z$ for slot milling in graphite	0.025 mm
Cutting edge $\varnothing D_c$	1 mm
Shank	DIN 6535 HA to h5
Direction of infeed	horizontal, oblique and vertical
Shank $\varnothing D_s$	4 mm
Flute length $L_c$	1.5 mm
Tolerance nominal $\varnothing$	0 / -0.005
Feed $f_z$ for side milling in graphite	0.03 mm
Helix angle	30 degrees
Correction factor $a_{p,corr}$	0.8
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