

**Garant**
**Solid carbide copy slot drill, Diamond, Ø DC × L1: 0,4X8 mm**

**Order data**

Order number	209791 0,4X8
GTIN	4045197919809
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:

- **Corner radius: Radius contour 0 / -0.005 mm.**
- **Neck Ø:  $D_1 = 0 / -0.01$  mm.**

**Note:**

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

copying:  $a_p = 0.15 \times D \times a_{p, \text{korr}}$

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

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

No. of teeth Z: 2

Helix angle: 25 degrees

No. of teeth Z: 2

Flute length  $L_c$ : 0.32 mm

Corner radius  $R_1$ : 0.2 mm

Overhang length  $L_1$  incl. recess: 8 mm

Recess Ø  $D_1$ : 0.37 mm

Overall length L: 45 mm

**Technical description**

Cutting edge Ø $D_c$	0.4 mm
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Flute length $L_c$	0.32 mm
Overhang length $L_1$ incl. recess	8 mm
Overall length $L$	45 mm
Shank $\varnothing D_s$	4 mm
Feed $f_z$ for copy milling in graphite	0.007 mm
No. of teeth $Z$	2
Recess $\varnothing D_1$	0.37 mm
Corner radius $R_1$	0.2 mm
Helix angle	25 degrees
Correction factor $a_{p,corr}$	0.08
Coating	Diamond
Tool material	Solid carbide
Standard	Manufacturer's standard
Tolerance nominal $\varnothing$	0 / -0.005
Direction of infeed	horizontal, oblique and vertical
Cutting width $a_e$ for milling operation	0.05×D for copy milling
Shank	DIN 6535 HA to h5
Through-coolant	no
Colour ring	black
Type of product	End mill