

## Garant

### Solid carbide copy slot drill, Diamond, Ø DC × L1: 1,5X25 mm



#### Order data

Order number	209791 1,5X25
GTIN	4045197920164
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: 30 degrees

No. of teeth Z: 2

Flute length  $L_c$ : 1.2 mm

Corner radius  $R_1$ : 0.75 mm

Overhang length  $L_1$  incl. recess: 25 mm

Recess Ø  $D_1$ : 1.44 mm

Overall length L: 70 mm

#### Technical description

No. of teeth Z	2
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Cutting edge $\varnothing D_c$	1.5 mm
Flute length $L_c$	1.2 mm
Overhang length $L_1$ incl. recess	25 mm
Recess $\varnothing D_1$	1.44 mm
Overall length $L$	70 mm
Shank $\varnothing D_s$	4 mm
Feed $f_z$ for copy milling in graphite	0.025 mm
Corner radius $R_1$	0.75 mm
Helix angle	30 degrees
Correction factor $a_{p,corr}$	0.12
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