

Garant

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



Order data

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| Order number | 209791 1X25 |
| GTIN | 4045197920058 |
| Item class | 11Y |

Description

Version:

With **crystalline diamond sp³ 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 : 0.8 mm

Corner radius R_1 : 0.5 mm

Overhang length L_1 incl. recess: 25 mm

Recess Ø D_1 : 0.96 mm

Overall length L: 70 mm

Technical description

| | |
|----------------|---------|
| Recess Ø D_1 | 0.96 mm |
|----------------|---------|

| | |
|---|----------------------------------|
| Flute length L_c | 0.8 mm |
| Overall length L | 70 mm |
| Shank $\varnothing D_s$ | 4 mm |
| No. of teeth Z | 2 |
| Cutting edge $\varnothing D_c$ | 1 mm |
| Feed f_z for copy milling in graphite | 0.02 mm |
| Overhang length L_1 incl. recess | 25 mm |
| Corner radius R_1 | 0.5 mm |
| Helix angle | 30 degrees |
| Correction factor $a_{p,corr}$ | 0.04 |
| 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 |