

Garant
GARANT Diabolo solid carbide micro slot drill, TiAlN, Ø DC×L1: 1X12mm

Order data

| | |
|--------------|---------------|
| Order number | 201632 1X12 |
| GTIN | 4062406386528 |
| Item class | 11X |

Description
Version:
GARANT Diabolo:

Special geometry, coating and carbide **for hard machining in the high-performance field.** Suitable even for **machining electrolytic copper.** Double-relief ground 2 chamfers hollow ground for high-precision hard machining.

Recess angle $\alpha = 16^\circ$.

Extra sturdy shank for achieving longer tool life.

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: $a_p = 0.05 \times D \times a_{p \text{ korr}}$

side milling: $a_p = 0.1 \times D \times a_{p \text{ korr}}$

To calculate the feed rate vf please use the actual speed of the machine (the maximum possible speed)! e.g: $vf = 18000 \text{ [rpm]} \times fz \text{ [mm/Z]} \times z$

Technical description

| | |
|---|-------------------|
| Shank | DIN 6535 HA to h5 |
| Feed f_z for slot milling in steel < 65 HRC | 0.012 mm |
| Tolerance nominal Ø | 0 / -0,005 |
| Correction factor $a_{p \text{ corr}}$ | 0.35 |
| Overhang length L_1 incl. recess | 12 mm |

| | |
|---|--------------------------------------|
| Shank $\varnothing D_s$ | 6 mm |
| Corner chamfer angle | 90 degrees |
| Direction of infeed | horizontal, oblique and vertical |
| Flute length L_c | 1.5 mm |
| No. of teeth Z | 2 |
| Helix angle | 30 degrees |
| Cutting edge $\varnothing D_c$ | 1 mm |
| Cutting speed v_c in steel < 65 HRC | 34 m/min |
| Overall length L | 54 mm |
| Recess $\varnothing D_1$ | 0.95 mm |
| Feed f_z for side milling in steel < 65 HRC | 0.017 mm |
| Series | Diabolo |
| Coating | TiAlN |
| Tool material | Solid carbide |
| Standard | Manufacturer's standard |
| Type | H |
| Cutting width a_e for milling operation | Full slot cutting depth $1 \times D$ |
| Cutting width a_e for milling operation | $0.1 \times D$ for side milling |
| Through-coolant | no |
| Colour ring | red |
| Type of product | End / face mill |

User data

| | Suitability | V_c | ISO code |
|--------------------------------|---|-----------|----------|
| Steel < 750 N/mm ² | suitable only under restricted conditions | 200 m/min | P |
| Steel < 900 N/mm ² | suitable only under restricted conditions | 200 m/min | P |
| Steel < 1100 N/mm ² | suitable | 190 m/min | P |

| | | | |
|--------------------------------|---|-----------|---|
| Steel < 1400 N/mm ² | suitable | 170 m/min | P |
| Steel < 50 HRC | suitable | 120 m/min | H |
| Steel < 55 HRC | suitable | 100 m/min | H |
| Steel < 60 HRC | suitable | 72 m/min | H |
| Steel < 65 HRC | suitable | 55 m/min | H |
| Steel < 67 HRC | suitable | 50 m/min | H |
| Steel < 70 HRC | suitable | 45 m/min | H |
| INOX < 900 N/mm ² | suitable | 90 m/min | M |
| INOX > 900 N/mm ² | suitable | 80 m/min | M |
| CuZn | suitable only under restricted conditions | 140 m/min | N |
| wet maximum | suitable only under restricted conditions | | |
| wet minimum | suitable only under restricted conditions | | |
| dry | suitable | | |
| Air | suitable | | |