

**Garant**
**Solid carbide copy slot drill, DLC, Ø DC × L1: 0,6X6mm**


## Order data

Order number	207025 0,6X6
GTIN	4062406377304
Item class	11X

## Description

### Version:

With **advanced DLC sp<sup>2</sup> coating**. For the **highest demands regarding performance and precision in aluminium materials**. **Extremely tight tolerances** ensure maximum accuracy. Double-relief ground with 2 chamfers.

Tolerances:

- **Corner radius: Radius contour = 0 / -0.005 mm.**
- **Neck Ø: D<sub>1</sub> = 0 / -0.01 mm.**

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

Extra-sturdy shank to reduce the tendency to vibrate.

### Note:

At greater tool overhang lengths, use a reduced value for a<sub>p</sub>!

values for:

copying:  $a_p = 0.25 \times D \times a_{p, \text{korr}}$

**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

Flute length L <sub>c</sub>	0.48 mm
Corner radius R <sub>1</sub>	0.3 mm
Cutting edge Ø D <sub>c</sub>	0.6 mm
Recess Ø D <sub>1</sub>	0.57 mm
Feed f <sub>z</sub> for copy milling in cast aluminium	0.02 mm

Shank $\varnothing D_s$	6 mm
Correction factor $a_{p\text{ corr}}$	0.5
Helix angle	25 degrees
Overall length L	55 mm
No. of teeth Z	2
Overhang length $L_1$ incl. recess	6 mm
Coating	DLC
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	W
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	yellow
Type of product	Ball-nosed slot drill

## User data

	Suitability	$V_c$	ISO code
Aluminium	suitable	480 m/min	N
Aluminium (short chipping)	suitable	440 m/min	N
Alu > 10% Si	suitable	400 m/min	N
PMMA acrylic	Suitable	200 m/min	N
PE-HD	Suitable	160 m/min	N
PA 66	Suitable	200 m/min	N
PEEK	Suitable	150 m/min	N
PF 31	Suitable	130 m/min	N

PVDF GF20	suitable	180 m/min	N
POM GF25	Suitable	160 m/min	N
PA 66 GF30	suitable	150 m/min	N
PEEK GF30	suitable	130 m/min	N
PTFE CF25	suitable	160 m/min	N
Honeycomb sandwich	suitable only under restricted conditions	300 m/min	N
Cu	suitable	160 m/min	N
CuZn	suitable	200 m/min	N
wet maximum	suitable		
wet minimum	suitable		
dry	suitable only under restricted conditions		
Air	suitable		