

Garant
GARANT Diabolo solid carbide ball nose slot drill HPC, TiAlN, Ø DC: 4mm

Order data

| | |
|--------------|---------------|
| Order number | 207424 4 |
| GTIN | 4045197600448 |
| Item class | 11X |

Description
Version:

Special geometry, coating and carbide for hard machining.
3 end face edges up to the centre. Can therefore be used as a true 3-flute drill in all cutting depths.

Tolerance: Radius contour = **±0.005 mm.**

Technical description

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|---|-------------------------|
| Feed f_z for copy milling in steel < 65 HRC | 0.019 mm |
| No. of teeth Z | 3 |
| Feed f_z for side milling in steel < 65 HRC | 0.019 mm |
| Cutting edge Ø D_c | 4 mm |
| Shank Ø D_s | 6 mm |
| Overall length L | 75 mm |
| Flute length L_c | 8 mm |
| Helix angle | 30 degrees |
| Radius R | 2 mm |
| Series | Diabolo |
| Coating | TiAlN |
| Tool material | Solid carbide |
| Standard | Manufacturer's standard |

| | |
|---|----------------------------------|
| Type | H |
| Tolerance nominal \varnothing | f8 |
| Direction of infeed | horizontal, oblique and vertical |
| Cutting width a_e for milling operation | 0.05×D for copy milling |
| Cutting width a_e for milling operation | 0.2×D for side milling |
| Shank | DIN 6535 HA to h6 |
| Through-coolant | no |
| Machining strategy | HPC |
| Colour ring | red |
| Type of product | Ball-nosed slot drill |

User data

| | Suitability | V_c | ISO code |
|--------------------------------|---|-----------|----------|
| Steel < 1400 N/mm ² | suitable | 200 m/min | P |
| Steel < 50 HRC | suitable | 190 m/min | H |
| Steel < 55 HRC | suitable | 170 m/min | H |
| Steel < 60 HRC | suitable | 150 m/min | H |
| Steel < 65 HRC | suitable | 110 m/min | H |
| wet maximum | suitable only under restricted conditions | | |
| wet minimum | suitable only under restricted conditions | | |
| dry | suitable | | |
| Air | suitable | | |

Services

| | |
|------------------------|-----------|
| Shank grinding Type HB | 129100 HB |
|------------------------|-----------|